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**(64)** Blade member, method for attaching blade member, process cartridge, method for assembling process cartridge and image forming apparatus.

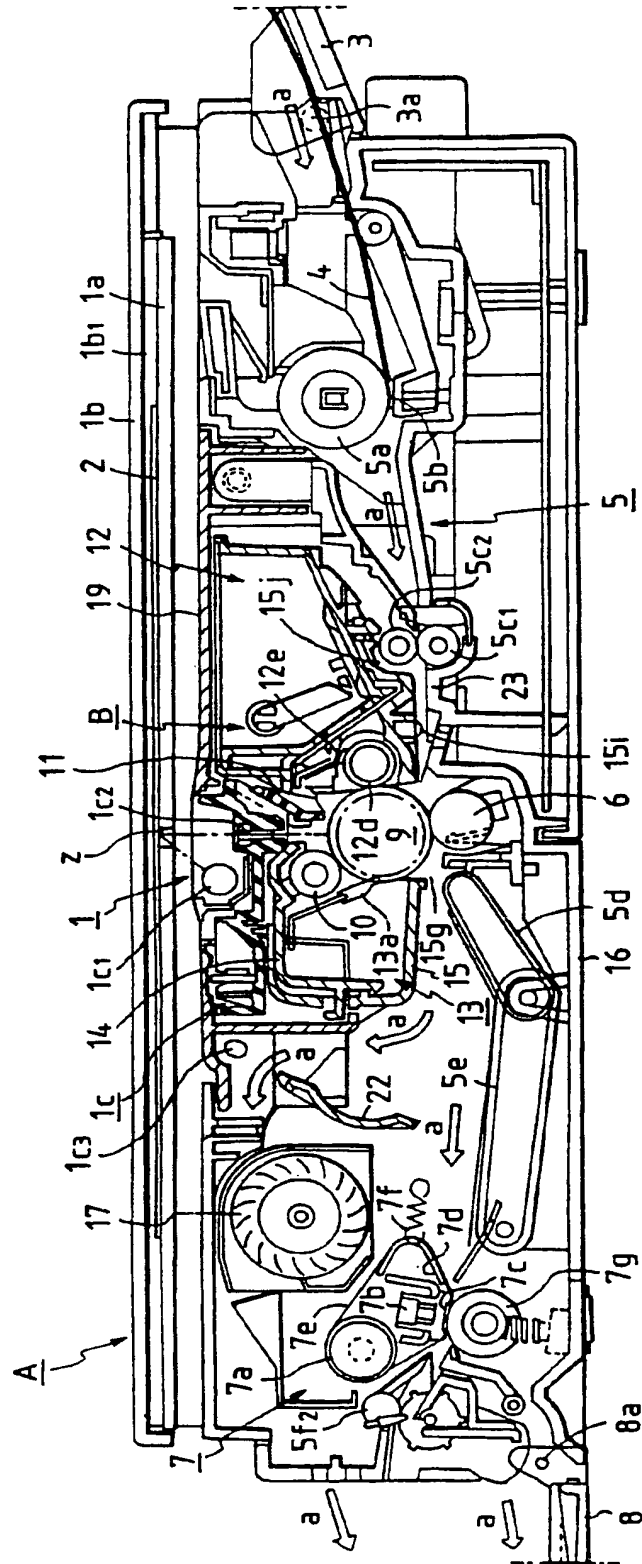
**(57)** The present invention provides blade members (12e ;13a) comprising an elastic blade, and a support member (S) for supporting the elastic blade and having a supporting portion for supporting the elastic blade, a protruded portion protruding from the supporting portion in a longitudinal direction thereof, and a hole formed in the protruded portion, and wherein a length of the protruded portion in the longitudinal direction is more than 5 mm and less than 20 mm.

There is additionally disclosed a mounting method for the blade into a processing cartridge, and a blade support design to facilitate the mounting action.

There is as well disclosed a design of a cleaning blade and a design for a recyclable processing cartridge.

**EP 0 570 249 A3**

FIG. 1





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## EUROPEAN SEARCH REPORT

Application Number

EP 93 40 0980

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	US-A-4 866 483 (DAVIS ET AL.) * column 4, line 16 - column 5, line 54; figure 6 * ---	1,16,19 ,22,23	G 03 G 15/00 G 03 G 15/08 G 03 G 21/00
A	EP-A-0 217 173 (MITA IND.) * column 19, line 35 - column 21, line 34; figures 11-14,16 * ---	1,16,19 ,22,23	
A	US-A-5 036 358 (YOSHIDA) * column 6, line 55 - column 7, line 13; figures 6,7 * -----	1,16,19 ,22,23	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			G 03 G
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 10-08-1993	Examiner LEISNER C O D
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document	
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			

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### CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing more than ten claims.

- ☐ All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid, namely claims:
- ☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

### LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions.

namely:

see sheet -B-

- ☐ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid, namely claims:
- ☒ None of the further search fees has been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims.

namely claims:

1-29



European Patent  
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EP 93 40 0980 -B-

**LACK OF UNITY OF INVENTION**

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims 1-29:  
Method of inserting a blade member into a frame member
2. Claims 30-41:  
Frame design for recyclable processing cartridge
3. Claims 42-55:  
Blade design to facilitate mounting of blade to a frame
4. Claims 56-77:  
Means for attaching blade member to frame
5. Claims 78-95:  
Design of blade member to be supported by a blade support member
6. Claims 96-123:  
Design of blade member for cleaning a photo-conductor in a copymachine

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(54) **Blade member, method for attaching blade member, process cartridge, method for assembling process cartridge and image forming apparatus.**

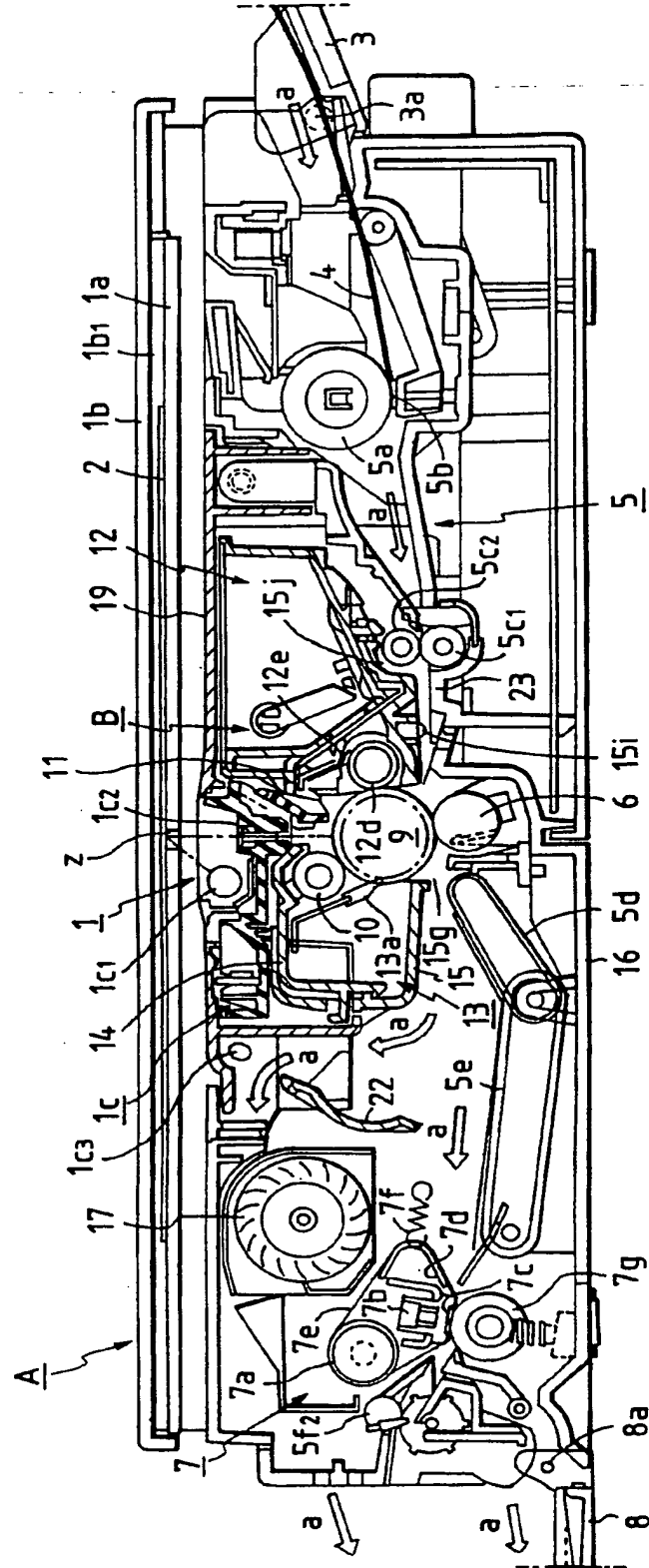
(57) The present invention provides blade members (12e ;13a) comprising an elastic blade, and a support member (S) for supporting the elastic blade and having a supporting portion for supporting the elastic blade, a protruded portion protruding from the supporting portion in a longitudinal direction thereof, and a hole formed in the protruded portion, and wherein a length of the protruded portion in the longitudinal direction is more than 5 mm and less than 20 mm.

There is additionally disclosed a mounting method for the blade into a processing cartridge, and a blade support design to facilitate the mounting action.

There is as well disclosed a design of a cleaning blade and a design for a recyclable processing cartridge.

EP 0 570 249 A2

FIG. 1





## BACKGROUND OF THE INVENTION

### Field of the Invention

The present invention relates to a blade member, a method for attaching a blade member, a process cartridge, a method for assembling a process cartridge and an image forming apparatus.

The image forming apparatus may be, for example, an electrophotographic copying machine, a laser beam printer, an LED printer, facsimile system, word processor and the like.

### Related Background Art

In image forming apparatus such as copying machines, a latent image is formed by selectively exposing an image bearing member uniformly charged, the latent image is then visualized with toner, and then the toner image is transferred onto a recording sheet, thereby forming an image on the recording sheet. In such image forming apparatus, whenever the toner is used up, new toner must be replenished. The toner replenishing operation not only is troublesome, but also often causes the contamination of the surroundings. Further, since the maintenance of various elements or members cannot be performed only by an expert in the art, most of the users feel inconvenient.

In order to eliminate such drawback and inconvenience, an image forming apparatus wherein parts such as a developing device which toner therein was used up or an image bearing member which a service life thereof was expired can easily be exchanged, thereby facilitating the maintenance, by assembling the image bearing member, a charger, the developing device and a cleaning device integrally as a process cartridge which can be removably mounted within the image forming apparatus has been proposed and put into practical use, for example, as disclosed in U.S. Patent Nos. 3,985,436, 4,500,195, 4,540,268 and 4,627,701.

By the way, in order to make an image forming apparatus compact, it has recently been required for making a process cartridge and various parts used with such process cartridge small-sized. On the other hand, in order to improve the assembling ability for the process cartridge, it has been requested for facilitating the assembling and disassembling of the parts used with the process cartridge.

This is because that the recycle of the process cartridges has strongly been desired in order to use the resources effectively in the view point of the protection of the global environment. To this end, it is desired to propose a process cartridge which can be recycled more easily. Incidentally, the recycle of the process cartridge means that, after a used process cartridge is collected and then is decomposed, damaged or worn parts are exchanged to new parts and

the other parts are reused as they are, thereby re-assembling the process cartridge.

Although the above-mentioned U.S. Patent 3,985,436 discloses the collection and recycle of a unit which has been used for a predetermined period, a preferred construction for the recycle is not disclosed concretely (refer to lines 38 - 62, column 16 in USP 3,985,436).

## SUMMARY OF THE INVENTION

An object of the present invention is to provide a blade member, a method for attaching a blade member, a process cartridge, a method for assembling a process cartridge and an image forming apparatus which can be made compact and which can improve the positional accuracy in attaching and/or assembling operations.

Another object of the present invention is to provide a blade member, a method for attaching a blade member, a process cartridge, a method for assembling a process cartridge and an image forming apparatus which can minimize the permanent deformation amount of parts, can prevent the turn-up (turn-over) of the blade member, can minimize the undesirable noise and can maintain the excellent performance for a long time.

A further object of the present invention is to provide a method for attaching a blade support member, a method for assembling a process cartridge having a blade attached thereto and an image forming apparatus within which such process cartridge can be mounted, which can maintain the attaching accuracy for the blade and which can facilitate the attachment of the blade.

A still further object of the present invention is to provide a process cartridge, an image forming apparatus within which such process cartridge can be mounted and a method for assembling a cleaning device, which can be suitably recycled.

A further object of the present invention is to provide a process cartridge, an image forming apparatus within which such process cartridge can be mounted and a method for assembling a cleaning device, which can improve the assembling ability.

A still further object of the present invention is to provide a process cartridge, an image forming apparatus within which such process cartridge can be mounted and a method for assembling a cleaning device, which can improve the disassembling ability.

The other object of the present invention is to provide a process cartridge, an image forming apparatus within which such process cartridge can be mounted and a method for assembling a cleaning device, wherein a used process cartridge collected from a market can efficiently be decomposed and which can suitably be recycled.

According to the present invention, it is possible

to provide a blade member, a method for attaching a blade member, a process cartridge, a method for assembling a process cartridge and an image forming apparatus which can be made compact.

### BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is an elevational sectional view of a copying machine within which a process cartridge according to a preferred embodiment of the present invention is mounted;  
 Fig. 2 is a perspective view of the copying machine in a condition that a tray is opened;  
 Fig. 3 is a perspective view of the copying machine in a condition that a tray is closed;  
 Fig. 4 is an elevational sectional view of the process cartridge;  
 Fig. 5 is a perspective view of the process cartridge;  
 Fig. 6 is a perspective view of the process cartridge in an inverted condition;  
 Fig. 7 is an exploded sectional view of the process cartridge in a condition that an upper frame and a lower frame are separated;  
 Fig. 8 is a perspective view of the lower frame showing an internal structure thereof;  
 Fig. 9 is a perspective view of the upper frame showing an internal structure thereof;  
 Fig. 10 is a longitudinal sectional view of a photosensitive drum of the process cartridge;  
 Fig. 11 is a schematic view for explaining the measurement of the charging noise;  
 Fig. 12 is a graph showing the result of the measurement of the charging noise regarding a position of a filler;  
 Fig. 13 is a perspective view of an earthing contact for the photosensitive drum;  
 Fig. 14 is a perspective view of an earthing contact for the photosensitive drum, according to another embodiment;  
 Fig. 15 is a perspective view showing an embodiment wherein an earthing contact which is not bifurcated is used with the photosensitive drum;  
 Fig. 16 is a sectional view of the non-bifurcated earthing contact used with the photosensitive drum;  
 Fig. 17 is an elevational view showing an attachment structure for a charger roller;  
 Fig. 18A is a perspective view of an exposure shutter, and Fig. 18B is a partial sectional view of the exposure shutter;  
 Fig. 19 is a sectional view showing a non-magnetic toner feeding mechanism having an agitating vane;  
 Fig. 20 is a longitudinal sectional view showing a positional relation between the photosensitive drum (9) and a developing sleeve (12d) and a structure for pressurizing the developing sleeve;

Fig. 21A is a sectional view taken along the line A - A of Fig. 20, and Fig. 21B is a sectional view taken along the line B - B of Fig. 20;

Fig. 22 is a sectional view for explaining the pressurizing force acting on the developing sleeve;  
 Fig. 23 is a perspective view of a squeegee sheet in a condition that an upper edge of the sheet is tortuous;

Fig. 24A is a perspective view showing a condition that a both-sided adhesive tape is protruded from a lower end of the squeegee sheet, and Figs. 24B and 24C are views showing a condition that a sticking tool is adhered to the protruded both-sided adhesive tape;

Fig. 25A is a perspective view showing a condition that the squeegee sheet is stuck to a curved attachment surface with a lower end portion of the sheet being curved, and Fig. 25B is a perspective view showing a condition that an upper end portion of the squeegee sheet is tensioned by releasing the curvature of the attachment surface;

Fig. 26 is a perspective view of a squeegee sheet according to another embodiment wherein a width of the sheet is widened straightly and gradually from both ends to a central portion thereof;  
 Fig. 27 is a perspective view for explaining the formation of the curvature of the squeegee sheet attachment surface by pressing the surface;

Fig. 28 is a view showing conditions that a recording medium is being guided by a lower surface of the lower frame;

Fig. 29 is a sectional view showing a condition that the photosensitive drum is finally assembled;

Fig. 30 is a sectional view showing a condition that a developing blade and a cleaning blade are stuck;

Fig. 31 is an exploded view for explaining the assembling of the process cartridge;

Fig. 32 is a view for explaining a position of guide members when the photosensitive drum of the process cartridge is assembled;

Fig. 33 is a sectional view of a structure wherein drum guides are arranged at ends of blade supporting members;

Fig. 34 is a perspective view for explaining the attachment of bearing members for the photosensitive drum and the developing sleeve;

Fig. 35 is a sectional view of the photosensitive drum and the developing sleeve with the bearing members attached thereto;

Fig. 36 is a perspective view for explaining a cover film and a tear tape;

Fig. 37 is a perspective view showing a condition that the tear tape is protruded from a gripper;

Fig. 38 is a schematic view showing a condition that the process cartridge is gripped by an oper-

ator's hand;

Fig. 39A is a flow chart showing the assembling and shipping line for the process cartridge, and Fig. 39B is a flow chart showing the disassembling and cleaning line for the process cartridge; Fig. 40 is a perspective view showing a condition that the process cartridge is being mounted within the image forming system;

Fig. 41 is a perspective view showing a condition that the process cartridge of Fig. 24 is being mounted within the image forming system;

Fig. 42 is a perspective view showing the arrangement of three contacts provided on the image forming system;

Fig. 43 is a sectional view showing the construction of the three contacts;

Fig. 44 is a sectional view for explaining the positioning of the relative position between the lower frame and a lens unit;

Fig. 45 is a sectional view for explaining the positioning of the relative position between the lower frame and an original glass support;

Fig. 46 is a perspective view showing the attachment positions of positioning pegs;

Fig. 47 is a schematic elevational view showing the relation between rotary shafts of the drum and of the sleeve and shaft supporting members therefor, and a transmitting direction of a driving force from a drive gear to a flange gear of the photosensitive drum;

Fig. 48 is an exploded perspective view of a developing sleeve according to an embodiment wherein it can easily be slid;

Fig. 49 is a schematic elevational view of the developing sleeve of Fig. 48;

Fig. 50 is an elevational sectional view showing a condition that the upper frame and the lower frame are released;

Fig. 51 is a view showing gears and contacts attached to the photosensitive drum;

Fig. 52A is an elevational view a developing sleeve receiving member according to another embodiment, and Fig. 52B is an end view of the receiving member of Fig. 52A;

Fig. 53 is an elevational view showing an arrangement wherein the developing blade and the cleaning blade can be attached to the interior of the image forming system by pins;

Fig. 54 an elevational view showing a condition that the photosensitive drum is being finally assembled, according to another embodiment;

Fig. 55 is an elevational sectional view of bearing members for supporting the photosensitive drum and the developing sleeve, according to another embodiment;

Fig. 56 is a schematic view of a transmission mechanism for transmitting a driving force from a drive motor of the image forming system to vari-

ous elements;

Figs. 57 and 58 are perspective views showing a condition that the flange gear of the photosensitive drum and a gear integral with the flange gear are protruded from the lower frame;

Fig. 59 is a view showing a gear train for transmitting a driving force from the drive gear of the image forming system to the photosensitive drum and the transfer roller;

Figs. 60A and 60B are views showing different drive transmitting mechanisms to developing sleeves, wherein magnetic toner is used and non-magnetic toner is used.

Fig. 61 is an exploded perspective view for explaining the attachment of the cleaning blade;

Fig. 62 is a partial plan view of the cleaning blade before attachment;

Fig. 63 is a partial plan view of the cleaning blade after attachment;

Figs. 64, 65 and 66 are plan views for explaining the assembling of the cleaning blade;

Fig. 67 is a partial plan view of a cleaning blade according to another embodiment wherein a fitting projection of the cleaning blade has a round end;

Fig. 68 is a partial perspective view of a cleaning blade according to a further embodiment wherein a fitting projection of the cleaning blade is rounded by chamfering a tapered portion thereof;

Fig. 69 is a partial plan view of a cleaning blade according to a still further embodiment wherein a tape is stuck to a tapered portion;

Fig. 70 is a partial plan view of a cleaning blade according to the other embodiment wherein oil is coated on a tapered portion;

Figs. 71A and 71B are explanatory views for showing a condition that fitting portions of a lower frame are widened by using a tool, in order to incorporate a cleaning blade therebetween;

Figs. 72A and 72B are explanatory views for showing a condition that the fitting portions of the lower frame are made narrower by using a tool;

Fig. 73 is a view showing a condition that the fitting portions of the lower frame are abutted against both longitudinal ends of a blade support member for a cleaning blade;

Fig. 74 is a perspective view of a cleaning blade;

Fig. 75 is a perspective view of a developing blade;

Figs. 76A to 76D are views for explaining a manner that a developing blade is attached,

Figs. 77A and 77B are views showing an embodiment wherein fitting margins are provided in a developing blade supporting portion;

Figs. 78A and 78B are views showing an embodiment wherein a developing blade supporting portion is tapered;

Figs. 79A and 79B are views for explaining a man-

ner that a protruded portion of a developing blade is fitted and supported;

Fig. 80 is a view showing an embodiment wherein only one end of a developing blade is fitted into a blade supporting portion;

Fig. 81 is a view showing an embodiment wherein only one end of a developing blade is secured by a screw;

Fig. 82 is a plan view of a cleaning blade and a blade support member integrally formed therewith;

Fig. 83 is a side view of the blade support member and the cleaning blade of Fig. 82;

Fig. 84 is a graph showing a relation between a length of a protruded portion of the blade support member in a longitudinal direction and a length from a lower end of the protruded portion to a leading end of the blade;

Fig. 85 is a schematic view showing a force acting on the blade;

Fig. 86 is a table showing an amount of the permanent deformation;

Fig. 87 is a schematic view showing an abutment angle; and

Fig. 88 is a graph showing a relation between the abut angle and the entry amount.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

First of all, a process cartridge according to a first embodiment of the present invention, and an image forming system utilizing such a process cartridge will be explained with reference to the accompanying drawings.

#### The Whole Construction of a Process Cartridge and an Image Forming Apparatus Mounting the Process Cartridge thereon:

First of all, the whole construction of the image forming apparatus will briefly be described. Incidentally, Fig. 1 is an elevational sectional view of a copying machine as an example of the image forming system, within which the process cartridge is mounted, Fig. 2 is a perspective view of the copying machine with a tray opened, Fig. 3 is a perspective view of the copying machine with the tray closed, Fig. 4 is an elevational sectional view of the process cartridge, Fig. 5 is a perspective view of the process cartridge, and Fig. 6 is a perspective view of the process cartridge in an inverted condition.

As shown in Fig. 1, the image forming apparatus A operates to optically read image information on an original or document 2 by an original reading means 1. A recording medium rested on a sheet supply tray 3 or manually inserted from the sheet supply tray 3 is fed, by a feeding means 5, to an image forming station

of the process cartridge B, where a developer (referred to as "toner" hereinafter) image formed in response to the image information is transferred onto the recording medium 4 by a transfer means 6. Thereafter, the recording medium 4 is sent to a fixing means 7 where the transferred toner image is permanently fixed to the recording medium 4. Then, the recording medium is ejected onto an ejection tray 8.

The process cartridge B defining the image forming station operates to uniformly charge a surface of a rotating photosensitive drum (image bearing member) 9 by a charger means 10, then to form a latent image on the photosensitive drum 9 by illuminating a light image read by the reading means 1 on the photosensitive drum by means of an exposure means 11, and then to visualize the latent image as a toner image by a developing means 12. After the toner image is transferred onto the recording medium 4 by the transfer means 6, the residual toner remaining on the photosensitive drum 9 is removed by a cleaning means 13.

Incidentally, the process cartridge B is formed as a cartridge unit by housing the photosensitive drum 9 and the like within frames which include a first or upper frame 14 and a second or lower frame 15. Further, in the illustrated embodiment, the frames 14, 15 are made of high impact styrol resin (HIPS), and a thickness of the upper frame 14 is about 2 mm and a thickness of the lower frame 15 is about 2.5 mm. However, material and thickness of the frames are not limited to the above, but may be selected appropriately.

Next, various parts of the image forming apparatus A and the process cartridge B mountable within the image forming apparatus will be fully described.

#### Image Forming Apparatus

First of all, various parts of the image forming apparatus A will be explained.

#### (Original Reading Means)

The original reading means 1 serves to optically read the information written on the original, and, as shown in Fig. 1, includes an original glass support 1a which is disposed at an upper portion of a body 16 of the image forming apparatus and on which the original 2 is to be rested. An original hold-down plate 1b moving a sponge layer 1b1 on its inner surface is attached to the original glass support 1a for opening and closing movement. The original glass support 1a and the original hold-down plate 1b are mounted on the apparatus body 16 for reciprocal sliding movement in the left and right directions in Fig. 1. On the other hand, a lens unit 1c is disposed below the original glass support 1a at the upper portion of the system body 16 and includes a light source 1c1 and a short focus focusing lens array 1c2 therein.

With this arrangement, when the original 2 is rested on the original glass support 1a with an image surface thereof faced downside and the light source 1c1 is activated and the original glass support 1a is slid in the left and right direction in Fig. 1, the photosensitive drum 9 of the process cartridge B is exposed by reflection light from the original 2 via the lens array 1c2.

#### (Recording Medium Feeding Means)

The feeding means 5 serves to feed the recording medium 4 rested on the sheet supply tray 3 to the image forming station and to feed the recording medium to the fixing means 7. More particularly, after a plurality of recording media 4 are stacked on the sheet supply tray 3 or a single recording medium 4 is manually inserted on the sheet supply tray 3, and leading end(s) of the recording media or medium are abutted against a nip between a sheet supply roller 5a and a friction pad 5b urged against the roller, when a copy start button A3 is depressed, the sheet supply roller 5a is rotated to separate and feed the recording medium 4 to a pair of regist rollers 5c1, 5c2 which, in turn, feed the recording medium is registration with the image forming operation. After the image forming operation, the recording medium 4 is fed to the fixing means 7 by a convey belt 5d and a guide member 5e, and then is ejected onto the ejection tray 8 by a pair of ejector rollers 5f1, 5f2.

#### (Transfer Means)

The transfer means 6 serves to transfer the toner image formed on the photosensitive drum 9 onto the recording medium 4 and, in the illustrated embodiment, as shown in Fig. 1, it comprises a transfer roller 6. More particularly, by urging the recording medium 4 against the photosensitive drum 9 in the process cartridge B mounted within the image forming apparatus by means of the transfer roller 6 provided in the image forming apparatus and by applying to the transfer roller 6 a voltage having the polarity opposite to that of the toner image formed on the photosensitive drum 9, the toner image on the photosensitive drum 9 is transferred onto the recording medium 4.

#### (Fixing Means)

The fixing means 7 serves to the toner image transferred to the recording medium 4 by applying the voltage to the transfer roller 6 and, as shown in Fig. 1, comprises a heat-resistive fixing film 7e wound around and extending between a driving roller 7a, a heating body 7c held by a holder 7b and a tension plate 7d. Incidentally, the tension plate 7d is biased by a tension spring 7f to apply a tension force to the film 7e. A pressure roller 7g is urged against the heating

body 7c with the interposition of the film 7e so that the fixing film 7e is pressurized against the heating body 7c with a predetermined force required to the fixing operation.

The heating body 7c is made of heat-resistive material such as alumina and has a heat generating surface comprised of a wire-shaped or plate-shaped members having a width of about 160  $\mu\text{m}$  and a length (dimension perpendicular to a plane of Fig. 1) of about 216 mm and made of  $\text{Ta}_2\text{N}$  for example arranged on an under surface of the holder 7b made of insulation material or composite material including insulation, and a protection layer made of  $\text{Ta}_2\text{O}$  for example and covering the heat generating surface. The lower surface of the heating body 7c is flat, and front and rear ends of the heating body are rounded to permit the sliding movement of the fixing film 7e. The fixing film 7e is made of heat-treated polyester and has a thickness of about 9  $\mu\text{m}$ . The film can be rotated in a clockwise direction by the rotation of the driving roller 7a. When the recording medium 4 to which the toner image was transferred passes through between the fixing film 7e and the pressure roller 7g, the toner image is fixed to the recording medium 4 by heat and pressure.

Incidentally, in order to escape or discharge the heat generated by the fixing means 7 out of the image forming apparatus, a cooling fan 17 is provided within the body 16 of the image forming apparatus. The fan 17 is rotated, for example when the copy start button A3 (Fig. 2) is depressed, so as to generate air flows a (Fig. 1) flowing into the image forming apparatus from the recording medium supply inlet and flow out from the recording medium ejecting outlet. The various parts including the process cartridge B are cooled by the air flows so that the heat does not remain in the image forming apparatus.

#### (Recording Medium Supply and Ejection Trays)

As shown in Figs. 1 to 3, the sheet supply tray 3 and the ejection tray 8 are mounted on shafts 3a, 8a, respectively within the system body 16 for pivotal movements in directions b in Fig. 2, and for pivotal movements around shafts 3b, 8b in directions c in Fig. 2. Locking projections 3c, 8c are formed on free ends of the trays 3, 8 at both sides thereof, respectively. These projections can be fitted into locking recesses 1b2 formed in an upper surface of the original hold-down plate 1b. Thus, as shown in Fig. 3, when the trays 3, 8 are folded inwardly to fit the locking projections 3c, 8c into the corresponding recesses 1b2, the original glass support 1a and the original hold-down plate 1b are prevented from sliding in the left and right directions. As a result, an operator can easily lift the image forming apparatus A via grippers 16a and transport it.

## (Setting Buttons for Density and the like)

Incidentally, setting buttons for setting the density and the like are provided on the image forming apparatus A. Briefly explaining, in Fig. 2, a power switch A1 is provided to turn ON and OFF the image forming apparatus. A density adjusting dial A2 is used to adjust the fundamental density (of the copied image) of the image forming apparatus. The copy start button A3, when depressed, starts the copying operation of the image forming apparatus. A copy clear button A4 when depressed, interrupts the copying operation and clears the various setting conditions (for example, the set density condition). A copy number counter button A5 serves to set the number of copies when depressed. An automatic density setting button A6, when depressed, automatically sets the density in the copying operation. A density setting dial A7 is provided so that the operator can adjust the copy density by rotating this dial at need.

Process Cartridge

Next, various parts of the process cartridge B which can be mounted within the image forming apparatus A will be explained.

The process cartridge B includes an image bearing member and at least one process means. For example, the process means may comprise a charge means for charging a surface of the image bearing member, a developing means for forming a toner image on the image bearing member and/or a cleaning means for removing the residual toner remaining on the image bearing member. As shown in Figs. 1 and 4, in the illustrated embodiment, the process cartridge B is constituted as a cartridge unit which can be removably mounted within the body 16 of the image forming apparatus, by enclosing the charger means 10, the developing means 12 containing the toner (developer) and the cleaning means 13 which are arranged around the photosensitive drum 9 as the image bearing member by a housing comprising the upper and lower frames 14, 15. The charger means 10, exposure means 11 (opening 11a) and toner reservoir 12a of the developing means 12 are disposed within the upper frame 14, and the photosensitive drum 9, developing sleeve 12d of the developing means 12 and cleaning means 13 are disposed within the lower frame 15.

Now, the various parts of the process cartridge B will be fully described regarding the charger means 11, exposure means 11, developing means 12 and cleaning means 13 in order. Incidentally, Fig. 7 is a sectional view of the process cartridge with the upper and lower frames separated from each other, Fig. 8 is a perspective view showing the internal construction of the lower frame, and Fig. 9 is a perspective view showing the internal construction of the upper frame.

## (Photosensitive Drum)

In the illustrated embodiment, the photosensitive drum 9 comprises a cylindrical drum core 9a having a thickness of about 1 mm and made of aluminium, and an organic photosensitive layer 9b disposed on an outer peripheral surface of the drum core, so that an outer diameter of the photosensitive drum 9 becomes 24 mm. The photosensitive drum 9 is rotated in a direction shown by the arrow in response to the image forming operation, by transmitting a driving force of a drive motor 54 (Fig. 56) of the image forming apparatus to a flange gear 9c (Fig. 8) secured to one end of the photosensitive drum 9.

During the image forming operation, when the photosensitive drum 9 is being rotated, the surface of the photosensitive drum 9 is uniformly charged by applying to the charger roller 10 (contacting with the drum 9) a vibrating voltage obtained by overlapping a DC voltage with an AC voltage. In this case, in order to uniformly charge the surface of the photosensitive drum 9, the frequency of the AC voltage applied to the charger roller 10 must be increased. However, if the frequency exceeds about 2000 Hz, the photosensitive drum 9 and the charger roller 10 will be vibrated, thus generating the so-called "charging noise".

That is to say, when the AC voltage is applied to the charger roller 10, an electrostatic attraction force is generated between the photosensitive drum 9 and the charger roller 10, so that the attraction force becomes maximum at the maximum and minimum values of the AC voltage, thus attracting the charger roller 10 against the photosensitive drum 9 while elastically deforming the charger roller. On the other hand, at an intermediate value of the AC voltage, the attraction force becomes minimum, with the result that the elastical deformation of the charger roller 10 is restored to try to separate the charger roller 10 from the photosensitive drum 9. Consequently, the photosensitive drum 9 and the charger roller 10 are vibrated at the frequency as twice as that of the applied AC voltage. Further, when the charger roller 10 is attracted against the photosensitive drum 9, the rotations of the drum and the roller are braked, thus causing the vibration due to the stick slip, which also results in the charging noise.

In order to reduce the vibration of the photosensitive drum 9, in the illustrated embodiment, as shown in Fig. 10 (sectional view of the drum), a rigid or elastic filler 9d is disposed within the photosensitive drum 9. The filler 9d may be made of metal such as aluminium, brass or the like, cement, ceramics such as gypsum, or rubber material such as natural rubber, in consideration of the productivity, workability, effect of weight and cost. The filler 9d has a solid cylindrical shape or a hollow cylindrical shape, and has an outer diameter smaller than an inner diameter of the photosensitive drum 9 by about 100  $\mu$ m, and is inserted

into the drum core 9a. That is to say, a gap between the drum core 9a and the filler 9d is set to have a value of 100  $\mu$ m at the maximum, and an adhesive (for example, cyanoacrylate resin, epoxy resin or the like) 9e is applied on the outer surface of the filler 9d or on the inner surface of the drum core 9a, and the filler 9d is inserted into the drum core 9a, thus adhering them to each other.

Now, the test results performed by the inventors, wherein the relation between the position of the filler 9d and the noise pressure (noise level) was checked by varying the position of the filler 9d in the photosensitive drum 9 will be explained. As shown in Fig. 11, the noise pressure was measured by a microphone M arranged at a distance of 30 cm from the front surface of the process cartridge B disposed in a room having the background noise of 43 dB. As result, as shown in Fig. 12, when the filler having a weight of 80 grams was arranged, at a central position in the longitudinal direction of the photosensitive drum 9, the noise pressure was 54.5 - 54.8 dB. Whereas, when the filler having a weight of 40 grams was arranged at a position offset from the central position toward the flange gear 9c by 30 mm, the noise pressure was minimum. From this result, it was found that it was more effective to arrange the filler 9d in the photosensitive drum 9 offset from the central position toward the gear flange 9c. The reason seems that one end of the photosensitive drum 9 is supported via the flange gear 9c while the other end of the drum 9 is supported by a bearing member 26 having no flange, so that the construction of the photosensitive drum 9 is not symmetrical with respect the central position in the longitudinal direction of the drum.

Thus, in the illustrated embodiment, as shown in Fig. 10, the filler 9d is arranged in the photosensitive drum 9 offset from the central position c (in the longitudinal direction of the drum) toward the flange gear 9c, i.e., toward the drive transmission mechanism to the photosensitive drum 9. Incidentally, in the illustrated embodiment, a filler 9d comprising a hollow aluminium member having a length L3 of 40 mm and a weight of about 20 - 60 grams, preferably 35 - 45 grams (most preferably about 40 grams) is positioned within the photosensitive drum 9 having a longitudinal length L1 of 257 mm at a position offset from the central position c toward the flange gear 9c by a distance L2 of 9 mm. By arranging the filler 9d within the photosensitive drum 9, the latter can be rotated stably, thus suppressing the vibration due to the rotation of the photosensitive drum 9 in the image forming operation. Therefore, even when the frequency of the AC voltage applied to the charger roller 10 is increased, it is possible to reduce the charging noise.

Further, in the illustrated embodiment, as shown in Fig. 10, an earthing contact 18a is contacted with the inner surface of the photosensitive drum 9 and the other end of the earthing contact is abutted

against a drum earth contact pin 35a, thereby electrically earthing the photosensitive drum 9. The earthing contact 18a is arranged at the end of the photosensitive drum opposite to the end adjacent to the flange gear 9c.

The earthing contact 18a is made of spring stainless steel, spring bronze phosphate or the like and is attached to the bearing member 26. More particularly, as shown in Fig. 13, the earthing contact comprises a base portion 18a1 having a locking opening 18a2 into which a boss formed on the bearing member 26 can be fitted, and two arm portions 18a3 extending from the base portion 18a1, each arm portion being provided at its free end with a semi-circular projection 18a4 protruding downwardly. When the bearing member 26 is attached to the photosensitive drum 9, the projections 18a4 of the earthing contact 18a are urged against the inner surface of the photosensitive drum 9 by the elastic force of the arm portions 18a3. In this case, since the earthing contact 18a is contacted with the photosensitive drum at plural points (two points), the reliability of the contact is improved, and, since the earthing contact 18a is contacted with the photosensitive drum via the semi-circular projections 18a4, the contact between the earthing contact and the photosensitive drum 9 is stabilized.

Incidentally, as shown in Fig. 14, lengths of the arm portions 18a3 of the earthing contact 18a may be differentiated from each other. With this arrangement, since positions where the semi-circular projections 18a4 are contacted with the photosensitive drum 9 are offset from each other in the circumferential direction of the drum, even if there is a crack portion extending in the axial direction in the inner surface of the photosensitive drum 9, both projections 18a4 do not contact with such crack portion simultaneously, thereby maintaining the earthing contact (between the contact and the drum) without fail. Incidentally, when the lengths of the arm portions 18a3 are differentiated, the contacting pressure between one of the arm portions 18a3 and the photosensitive drum is differentiated from the contacting pressure between the other arm portion and the drum. However, such difference can be compensated, for example, by changing the bending angles of the arm portions 18a3.

In the illustrated embodiment, while the earthing contact 18a had two arm portions 18a3 as mentioned above, three or more arm portions may be provided, or, when the earthing contact is contacted with the inner surface of the photosensitive drum 9 without fail, a single arm portion 18a3 (not bifurcated) having no projection may be used, as shown in Figs. 15 and 16.

Now, if the contacting pressure between the earthing contact 18a and the inner surface of the photosensitive drum 9 is too weak, the semi-circular projections 18a4 cannot follow the unevenness of the inner surface of the photosensitive drum, thus caus-

ing the poor contact between the earthing contact and the photosensitive drum and generating the noise due to the vibration of the arm portions 18a3. In order to prevent such poor contact and noise, the contacting pressure must be increased. However, if the contacting pressure is too strong, when the image forming system is used for a long time, the inner surface of the photosensitive drum will be damaged by the high pressure of the semi-circular projections 18a4. Consequently, when the semi-circular projections 18a4 pass through such damaged portion, the vibration occurs, thus causing the poor contact and the vibration noise. In consideration of the above affairs, it is preferable that the contacting pressure between the earthing contact 18a and the inner surface of the photosensitive drum is set in a range between about 10 grams and about 200 grams. That is to say, according to the test result effected by the inventors, when the contacting pressure was smaller than about 10 grams, it was feared that the poor contact was likely to occur in response to the rotation of the photosensitive drum, thus causing the radio wave jamming regarding other electronic equipments. On the other hand, when the contacting pressure was greater than about 200 grams, it was feared that the inner surface of the photosensitive drum 9 was damaged due to the sliding contact between the drum inner surface and the earthing contact 18a for a long time, thus causing the abnormal noise and/or poor contact.

Incidentally, although the generation of the above noise and the like sometimes cannot be eliminated completely because of the inner surface condition of the photosensitive drum, it is possible to reduce the vibration of the photosensitive drum 9 by arranging the filler 9d within the drum 9, and it is also possible to prevent the damage of the drum and the poor contact more effectively by disposing the conductive grease on the contacting area between the earthing contact 18a and the inner surface of the photosensitive drum 9. Further, since the earthing contact 18a positioned on the bearing member 26 situated remote from the filler 9d offset toward the flange gear 9c, the earthing contact can easily be attached to the bearing member.

#### (Charger Means)

The charger means serves to charge the surface of the photosensitive drum 9. In the illustrated embodiment, the charger means is of so-called contact charging type as disclosed in the Japanese Patent Laid-open Appln. No. 63-149669. More specifically, as shown in Fig. 4, the charger roller 10 is rotatably mounted on the inner surface of the upper frame 14 via a slide bearing 10c. The charger roller 10 comprises a metallic roller shaft 10b (for example, a conductive metal core made of iron, SUS or the like), an elastic rubber layer made of EPDM, NBR or the like and

arranged around the roller shaft, and an urethane rubber layer dispersing carbon therein and arranged around the elastic rubber layer, or comprise a metallic roller shaft and a foam urethane rubber layer dispersing carbon therein. The roller shaft 10b of the charger roller 10 is held by bearing slide guide pawls 10d of the upper frame 14 via the slide bearing 10c so that it cannot detached from the upper frame and it can slightly be moved toward the photosensitive drum 9. The roller shaft 10b is biased by a spring 10a so that the charger roller 10 is urged against the surface of the photosensitive drum 9. Thus, the charger means is constituted by the charger roller 10 incorporated into the upper frame 14 via the bearing 10c. In the image forming operation, when the charger roller 10 is driven by the rotation of the photosensitive drum 9, the surface of the photosensitive drum 9 is uniformly charged by applying the overlapped DC and AC voltage to the charger roller 10 as mentioned above.

Now, the voltage applied to the charger roller 10 will be described. Although the voltage applied to the charger roller 10 may be the DC voltage alone, in order to achieve the uniform charging, the vibration voltage obtained by overlapping the DC voltage and the AC voltage as mentioned above should be applied to the charger roller. Preferably, the vibration voltage obtained by overlapping the DC voltage having the peak-to-peak voltage value greater, by twice or more, than the charging start voltage when the DC voltage alone is used, and the AC voltage is applied to the charger roller 10 to improve the uniform charging (refer to the Japanese Patent Laid-open Appln. No. 63-149669). The "vibration voltage" described herein means a voltage that the voltage value is periodically changed as a function of time and that preferably has the peak-to-peak voltage greater, by twice or more, than the charging start voltage when the surface of the photosensitive drum is charged only by the DC voltage. Further, the wave form of the vibration voltage is not limited to the sinusoidal wave, but may be rectangular wave, triangular wave or pulse wave. However, the sinusoidal wave not including the higher harmonic component is preferable in view of the reduction of the charging noise. The DC voltage may include a voltage having the rectangular wave obtained by periodically turning ON/OFF a DC voltage source, for example.

As shown in Fig. 17, the application of the voltage to the charger roller 10 is accomplished by urging one end 18c1 of a charging bias contact 18c against a charging bias contact pin of the image forming apparatus as will be described later, and the other end 18c2 of the charging bias contact 18c is urged against the metallic roller shaft 10b, thereby applying the voltage to the charger roller 10. Incidentally, since the charger roller 10 is biased by the elastic contact 18c toward the right in Fig. 17, the charger roller bearing 10c disposed remote from the contact 18c has a



hooked stopper portion 10c1. Further, a stopper portion 10e depending from the upper frame 14 is arranged near the contact 18c in order to prevent the excessive axial movement of the charger roller 10 when the process cartridge B is dropped or vibrated.

In the illustrated embodiment, with the arrangement as mentioned above, the voltage of 1.6 - 2.4 KVV<sub>pp</sub>, - 600 VV<sub>DC</sub> (sinusoidal wave) is applied to the charger roller 10.

When the charger roller 10 is incorporated into the upper frame 14, first of all, the bearing 10c is supported by the guide pawls 10d of the upper frame 14 and then the roller shaft 10b of the charger roller 10 is fitted into the bearing 10c. And, when the upper frame 14 is assembled with the lower frame 15, the charger roller 10 is urged against the photosensitive drum 9, as shown in Fig. 4.

Incidentally, the bearing 10c for the charger roller 10 is made of conductive bearing material including a great amount of carbon filler, and the voltage is applied to the charger roller 10 from the charging bias contact 18c via the metallic spring 10a so that the stable charging bias can be supplied.

#### (Exposure Means)

The exposure means 11 serves to expose the surface of the photosensitive drum 9 uniformly charged by the charger roller 10 with a light image from the reading means 1. As shown in Figs. 1 and 4, the upper frame 14 is provided with an opening 11a through which the light from the lens array 1c2 of the image forming system is illuminated onto the photosensitive drum 9. Incidentally, when the process cartridge B is removed from the image forming apparatus A, if the photosensitive drum 9 is exposed by the ambient light through the opening 11a, it is feared that the photosensitive drum is deteriorated. To avoid this, a shutter member 11b is attached to the opening 11a so that when the process cartridge B is removed from the image forming apparatus A the opening 11a is closed by the shutter member 11b and when the process cartridge is mounted within the image forming apparatus the shutter member opens the opening 11a.

As shown in Figs. 18A and 18B, the shutter member 11b has an L-shaped cross-section having a convex portion directing toward the outside of the cartridge, and is pivotally mounted on the upper frame 14 via pins 11b1. A torsion coil spring 11c is mounted around one of the pins 11b1 so that the shutter member 11b is biased by the coil spring 11c to close the opening 11a in a condition that the process cartridge B is dismounted from the image forming apparatus A.

As shown in Fig. 18A, abutment portions 11b2 are formed on the outer surface of the shutter member 11b so that, when the process cartridge B is mounted within the image forming apparatus A and an upper opening/closing cover 19 (Fig. 1) openable with re-

spect to the body 16 of the image forming apparatus is closed, a projection 19a formed on the cover 19 is abutted against the abutment portions 11b2, thereby rotating the shutter member 11b in a direction shown by the arrow e (Fig. 18B) to open the opening 11a.

In the opening and closing operation of the shutter member 11b, since the shutter member 11b has the L-shaped cross-section and the abutment portions 11b2 are disposed outwardly of the contour of the cartridge B and near the pivot pins 11b1, as shown in Figs. 4 and 18B, the shutter member 11b is abutted against the projection 19a of the cover 19 outwardly of the contour of the process cartridge B. As a result, even when the opening and closing angle of the shutter member 11b is small, a leading end of the rotating shutter member 11b is surely opened, thereby surely illuminating the light from the lens array 1c2 disposed above the shutter member onto the photosensitive drum to form the good electrostatic latent image on the surface of the photosensitive drum 9. By constituting the shutter member 11b as mentioned above, when the process cartridge B is inserted into the image forming system, it is not necessary to retard the cartridge B from the shutter opening projection 19a of the cover 19 of the image forming apparatus, with the result that it is possible to shorten the stroke of the projection, thereby making the process cartridge B and the image forming apparatus A small-sized.

#### (Developing Means)

Next, the developing means 12 will be explained. The developing means 12 serves to visualize the electrostatic latent image formed on the photosensitive drum 9 by the exposure means with toner as a toner image. Incidentally, in this image forming apparatus A, although magnetic toner or non-magnetic toner can be used, in the illustrated embodiment, the developing means in the process cartridge B includes the magnetic toner as one-component magnetic developer.

Binder resin of the one-component magnetic toner used in the developing operation may be the following or a mixture of the following polymer of styrene and substitute thereof such as polystyrene and polyvinyltoluene; styrene copolymer such as styrene-propylene copolymer, styrene-vinyltoluene copolymer, styrene-vinylnaphthalene copolymer, styrene-acrylic acid ethyl copolymer or styrene-acrylic acid butyl copolymer; polymethylmethacrylate, polybutylmethacrylate, polyvinylacetate, polyethylene, polypropylene, polyvinylbutyral, polycrylic acid resin, rosin, modified rosin, turpentine resin, phenolic resin, aliphatic hydrocarbon resin, alicyclic hydrocarbon resin, aromatic petroleum resin, paraffin wax, carnauba wax or the like.

As for the coloring material added to the magnet-

ic toner it may be known carbon black, copper phthalocyanine, iron black or the like. The magnetic fine particles contained in the magnetic toner may be of the material magnetizable when placed in the magnetic field, such as ferromagnetic powder of metal such as iron, cobalt, and nickel, powder of metal alloy or powder of compound such as magnetite or ferrite.

As shown in Fig. 4, the developing means 12 for forming the toner image with the magnetic toner has a toner reservoir 12a for containing the toner, and a toner feed mechanism 12b disposed within the toner reservoir 12a and adapted to feed out the toner. Further, the developing means is so designed that the developing sleeve 12d having a magnet 12c therein is rotated to form a thin toner layer on a surface of the developing sleeve. When the toner layer is being formed on the developing sleeve 12d, the developable frictional charging charges are applied to the electrostatic latent image on the photosensitive drum 9 by the friction between the toner and the developing sleeve 12d. Further, in order to regulate a thickness of the toner layer, a developing blade 12e is urged against the surface of the developing sleeve 12d. The developing sleeve 12d is disposed in a confronting relation to the surface of the photosensitive drum 9 with a gap of about 100 - 400  $\mu$ m therebetween.

As shown in Fig. 4, the magnetic toner feed mechanism 12b has feed members 12b1 made of polypropylene (PP), acrylobutadienestyrol (ABS), high-impact styrol (HIPS) or the like and reciprocally shiftable in a direction shown by the arrows f along a bottom surface of the toner reservoir 12a. Each feed member 12b1 has a substantial triangular cross-section and is provided with a plurality of long rod members extending along the rotation axis of the photosensitive drum (direction perpendicular to the plane of Fig. 4) for scraping the whole bottom surface of the toner reservoir 12a. The rod members are interconnected at their both ends to constitute an integral structure. Further, there are three feed members 12b1, and the shifting range of the feed members are selected to be greater than a bottom width of the triangular cross-section so that all of the toner on the bottom surface of the toner reservoir can be scraped. In addition, an arm member 12b2 is provided at its free end with a projection 12b6, thereby preventing the feed members 12b1 from floating and being disordered.

The feed member 12b1 has a lock projection 12b4 at its one longitudinal end, which projection is rotatably fitted into a slot 12b5 formed in the arm member 12b2. The arm member 12b2 is rotatably mounted on the upper frame 14 via a shaft 12b3 and is connected to an arm (not shown) disposed outside the toner reservoir 12a. Further, a drive transmitting means is connected to the feed members 12b1 so that, when the process cartridge B is mounted within the image forming apparatus A, the driving force from the image

forming apparatus is transmitted to the feed members to swing the arm member 12b2 around the shaft 12b3 by a predetermined angle. Incidentally, as shown in Fig. 7 and the like, the feed members 12b1 and the arm member 12b2 may be integrally formed from resin such as polypropylene, polyamide or the like so that they can be folded at a connecting portion therebetween.

Accordingly, in the image forming operation, when the arm member 12b2 is rocked by the predetermined angle, the feed members 12b1 are reciprocally shifted along the bottom surface of the toner reservoir 12a in directions f between a condition shown by the solid lines and a condition shown by the broken lines. Consequently, the toner situated near the bottom surface of the toner reservoir 12a is fed toward the developing sleeve 12d by the feed members 12b1. In this case, since each feed member 12b1 has the triangular cross-section, the toner is scraped by the feed members and is gently fed along inclined surfaces of the feed members 12b1. Thus, the toner near the developing sleeve 12d is hard to be agitated, and, therefore, the toner layer formed on the surface of the developing sleeve 12d is hard to be deteriorated.

Further, as shown in Fig. 4, a lid member 12f of the toner reservoir 12a is provided with a depending member 12f1. A distance between a lower end of the depending member 12f1 and the bottom surface of the toner reservoir is selected so as to be slightly greater than a height of the triangular cross-section of each toner feed member 12b1. Accordingly, the toner feed member 12b1 is reciprocally shifted between the bottom surface of the toner reservoir and the depending member 12f1, with the result that, if the feed member 12b1 tries to float from the bottom surface of the toner reservoir, such floating is limited or regulated, thus preventing the floating of the feed members 12b1.

Incidentally, the image forming apparatus A according to the illustrated embodiment can also receive a process cartridge including the non-magnetic toner. In this case, the toner feed mechanism is driven to agitate the non-magnetic toner near the developing sleeve 12d.

That is to say, when the non-magnetic toner is used, as shown in Fig. 19, an elastic roller 12g rotated in a direction same as that of the developing sleeve 12d feeds the non-magnetic toner fed from the toner reservoir 12a by the toner feed mechanism 12b toward the developing sleeve 12d. In this case, at a nip between the developing sleeve 12d and the elastic roller 12g, the toner on the elastic roller 12g is frictionally charged by the sliding contact between the toner and the developing sleeve 12d to be adhered onto the developing sleeve 12d electrostatically. Thereafter, during the rotation of the developing sleeve 12d, the non-magnetic toner adhered to the developing sleeve

12d enters into an abutment area between the developing blade 12e and the developing sleeve 12d to form the thin toner layer on the developing sleeve, and the toner is frictionally charged by the sliding contact between the toner and the developing sleeve with the polarity sufficiently to develop the electrostatic latent image. However, when the toner remains on the developing sleeve 12d, the remaining toner is mixed with the new toner fed to the developing sleeve 12d and is fed to the abutment area between the developing sleeve and the developing blade 12e. The remaining toner and the new toner are frictionally charged by the sliding contact between the toner and the developing sleeve 12d. In this case, however, although the new toner is charged with the proper charge, since the remaining toner is further charged from the condition that it has already been charged with the proper charge, it is over-charged. The over-charged or excessively charged toner has the adhesion force (to the developing sleeve 12d) stronger than that of the properly charged toner, thus becoming harder to use in the developing operation.

To avoid this, in the illustrated embodiment, regarding the process cartridge containing the non-magnetic toner, as shown in Fig. 19, the non-magnetic toner feed mechanism 12h comprises a rotary member 12h1 disposed in the toner reservoir 12a, which rotary member 12h1 has an elastic agitating vane 12h2. When the non-magnetic toner cartridge is mounted within the image forming apparatus A, the drive transmitting means is connected to the rotary member 12h1 so that the latter is rotated by the image forming apparatus in the image forming operation. In this way, when the image is formed by using the cartridge containing the non-magnetic toner and mounted within the image forming apparatus, the toner in the toner reservoir 12a is greatly agitated by the agitating vane 12h2. As a result, the toner near the developing sleeve 12d is also agitated to be mixed with the toner in the toner reservoir 12a, thereby dispersing the charging charges removed from the developing sleeve 12d in the toner within the toner reservoir to prevent the deterioration of the toner.

By the way, the developing sleeve 12d on which the toner layer is formed is arranged in a confronting relation to the photosensitive drum 9 with a small gap therebetween (about 300  $\mu\text{m}$  regarding the process cartridge containing the magnetic toner, or about 200  $\mu\text{m}$  regarding the process cartridge containing the non-magnetic toner). Accordingly, in the illustrated embodiment, abutment rings each having an outer diameter greater than that of the developing sleeve by an amount corresponding to the small gap are arranged in the vicinity of both axial ends of the developing sleeve 12d and outside the toner layer forming area so that these rings are abutted against the photosensitive drum 9 at zones outside the latent image forming area.

Now, the positional relation between the photosensitive drum 9 and the developing sleeve 12d will be explained. Fig. 20 is a longitudinal sectional view showing a positional relation between the photosensitive drum 9 and the developing sleeve 12d and a structure for pressurizing the developing sleeve, Fig. 21A is a sectional view taken along the line A - A of Fig. 20, and Fig. 21B is a sectional view taken along the line B - B of Fig. 20.

As shown in Fig. 20, the developing sleeve 12d on which the toner layer is formed is arranged in a confronting relation to the photosensitive drum 9 with the small gap therebetween (about 200 - 300  $\mu\text{m}$ ). In this case, the photosensitive drum 9 is rotatably mounted on the lower frame 15 by rotatably supporting a rotary shaft 9f of the flange gear 9c at the one end of the drum via a supporting member 33. The other end of the photosensitive drum 9 is also rotatably mounted on the lower frame 15 via a bearing portion 26a of the bearing member 26 secured to the lower frame. The developing sleeve 12d has the above-mentioned abutment rings 12d1 each having the outer diameter greater than that of the developing sleeve by the amount corresponding to the small gap and arranged in the vicinity of both axial ends of the developing sleeve and outside the toner layer forming area so that these rings are abutted against the photosensitive drum 9 at the zones outside the latent image forming area.

Further, the developing 12d is rotatably supported by sleeve bearings 12i disposed between the abutment rings 12d1 in the vicinity of both axial ends of the developing sleeve and outside the toner layer forming area, which sleeve bearings 12i are mounted on the lower frame 15 in such a manner that they can be slightly shifted in directions shown by the arrow g in Fig. 20. Each sleeve bearing 12i has a rearwardly extending projection around which an urging spring 12j having one end abutted against the lower frame 15 is mounted. Consequently, the developing sleeve 12d is always biased toward the photosensitive drum 9 by these urging springs. With this arrangement, the abutment rings 12da are always abutted against the photosensitive drum 9, with the result that the predetermined gap between the developing sleeve 12d and the photosensitive drum 9 is always maintained, thereby transmitting the driving force to the flange gear 9c of the photosensitive drum 9 and a sleeve gear 12k of the developing sleeve 12d meshed with the flange gear 9c.

The sleeve gear 12k also constitutes a flange portion of the developing sleeve 12d. That is to say, according to the illustrated embodiment, the sleeve gear 12k and the flange portion are integrally formed from resin material (for example, polyacetylene resin). Further, a metallic pin 12d2 having a small diameter (for example, made of stainless steel) and having one end rotatably supported by the lower frame 15 is

press-fitted into a secured to the sleeve gear 12k (flange portion) at its center. This metallic pin 12d2 acts as a rotary shaft at one end of the developing sleeve 12d. According to the illustrated embodiment, since the sleeve gear and the flange portion can be integrally formed from resin, it is possible to facilitate the manufacturing of the developing sleeve and to make the developing sleeve 12d and the process cartridge B light-weighted.

Now, the sliding directions of the sleeve bearings 12i will be explained with reference to Fig. 22. First of all, the driving of the developing sleeve 12d will be described. When the driving force is transmitted from the drive source (drive motor 54) of the image forming apparatus to the flange gear 9c and then is transmitted from the flange gear 9c to the sleeve gear 12k, the meshing force between the gears is directed to a direction inclined or offset from a tangential line contacting a meshing pitch circle of the flange gear 9c and a meshing pitch circle of the sleeve gear 12k by a pressure angle ( $20^\circ$  in the illustrated embodiment). Thus, the meshing force is directed to a direction shown by the arrow P in Fig. 22 ( $\theta = 20^\circ$ ). In this case, if the sleeve bearings 12i are slid in a direction parallel to a line connecting the center of rotation of the photosensitive drum 9 and the center of rotation of the developing sleeve 12d, when the meshing force P is divided into a force component Ps of a horizontal direction parallel with the sliding direction and a force component Ph of a vertical direction perpendicular to the sliding direction, as shown in Fig. 22, the force component of the horizontal direction parallel with the sliding direction is directed away from the photosensitive drum 9. As a result, regarding the driving of the developing sleeve 12d, the distance between the photosensitive drum 9 and the developing sleeve 12d is easily varied in accordance with the meshing force between the flange gear 9c and the sleeve gear 12k, with the result that the toner on the developing sleeve 12d cannot be moved to the photosensitive drum 9 properly, thus worsening the developing ability.

To avoid this, in the illustrated embodiment, as shown in Fig. 21A, in consideration of the transmission of the driving force from the flange gear 9c to the sleeve gear 12k, the sliding direction of the sleeve bearing 12i at the driving side (side where the sleeve gear 12k is disposed) is coincided with directions shown by the arrow Q. That is to say, an angle  $\phi$  formed between the direction of the meshing force P (between the flange gear 9c and the sleeve gear 12k) and the sliding direction is set to have a value of about  $90^\circ$  ( $92^\circ$  in the illustrated embodiment). With this arrangement, the force component Ps of the horizontal direction parallel with the sliding direction is negligible, and, in the illustrated embodiment, the force component Ps acts to slightly bias the developing sleeve 12d toward the photosensitive drum 9. In such a case, the developing sleeve 12d is pressurized by an

amount corresponding to spring pressure  $\alpha$  of the urging springs 12j to maintain the distance between the photosensitive drum 9 and the developing sleeve 12d constant, thereby ensuring the proper development.

Next, the sliding direction of the slide bearing 12i at the non-driving side (side where the sleeve gear 12k is not arranged) will be explained. At the non-driving side, unlike to the above-mentioned driving side, since the slide bearing 12i does not receive a driving force, as shown in Fig. 21B, the sliding direction of the slide bearing 12i is selected to be substantially parallel with a line connecting a center of the photosensitive drum 9 and a center of the developing sleeve 12d.

In this way, when the developing sleeve 12d is pressurized toward the photosensitive drum 9, by changing the urging angle for urging the developing sleeve 12d at the driving side from that at the non-driving side, the positional relation between the developing sleeve 12d and the photosensitive drum 9 is always maintained properly, thus permitting the proper development.

Incidentally, the sliding direction of the slide bearing 12i at the driving side may be set to be substantially parallel with the line connecting the center of the photosensitive drum 9 and the center of the developing sleeve 12d as in the case of the non-driving side. That is to say, as described in the above-mentioned embodiment, at the driving side, since the developing sleeve 12d is urged away from the photosensitive drum 9 by the force component Ps (of the meshing force between the flange gear 9c and the sleeve gear 12k) directing toward the sliding direction of the slide bearing 12i, in this embodiment, the urging force of the urging spring 12j at the driving side may be set to have a value greater than that at the non-driving side by an amount corresponding to the force component Ps. That is, when the urging force of the urging spring 12j to the developing sleeve 12d at the non-driving side is P, the urging force P2 of the urging spring 12j at the driving side is set to have a relation  $P2 = P1 + Ps$ , with the result that the developing sleeve 12d is always subjected to the proper urging force, thus ensuring the constant distance between the developing sleeve and the photosensitive drum 9.

#### (Cleaning Means)

The cleaning means 13 serves to remove the residual toner remaining on the photosensitive drum 9 after the toner image on the photosensitive drum 9 has been transferred to the recording medium 4 by the transfer means 6. As shown in Fig. 4, the cleaning means 13 comprises an elastic cleaning blade 13a contacting with the surface of the photosensitive drum 9 and adapted to remove or scrape off the residual toner remaining on the photosensitive drum 9, a squeegee sheet 13b slightly contacting with the

surface of the photosensitive drum 9 and disposed below the cleaning blade 13a to receive the removed toner, and a waste toner reservoir 13c for collecting the waste toner received by the sheet 13b. Incidentally, the squeegee sheet 13b is slightly contacted with the surface of the photosensitive drum 9 and the serves to permit the passing of the residual toner remaining on the photosensitive drum, but to direct the toner removed from the photosensitive drum 9 by the cleaning blade 13a to a direction away from the surface of the photosensitive drum 9.

Now, a method for attaching the squeegee sheet 13b will be described. The squeegee sheet 13b is adhered to an attachment surface 13d of the waste toner reservoir 13c via both-side adhesive tape 13e. In this case, the waste toner reservoir 13c is made of resin material (for example, high-impact styrol (HIPS) or the like) and has a slight uneven surface. Thus, as shown in Fig. 23, if the both-sided adhesive tape 13e is merely stuck to the attachment surface 13d and the squeegee sheet 13b is merely attached to the adhesive tape 13e, it is feared that a free edge of the squeegee sheet 13b (to be contacted with the photosensitive drum 9) is tortuous shown by x. If such a tortuous edge x of the squeegee sheet 13b is generated, the squeegee sheet 13b does not closely contact with the surface of the photosensitive drum 9, so that it cannot surely receive the toner removed by the cleaning blade 13a.

In order to avoid this, it is considered that, when the squeegee sheet 13b is attached to the attachment surface, as shown in Fig. 24A, the attachment surface 13d at a lower portion of the waste toner reservoir is pulled downwardly by a pulling tool 20 to elastically deform the attachment surface to for a curvature and then the squeegee sheet 13b is stuck to the curved attachment surface, and, thereafter the curvature of the attachment surface is released to apply the tension to the free edge of the squeegee sheet 13b, thereby preventing the free edge from becoming tortuous. However, in the recent small-sized process cartridges B, since the dimension of the attachment surface 13d is small, if the squeegee sheet 13b is stuck to the curved attachment surface 13d, as shown in Fig. 24A, both lower ends or corners 13b1 of the squeegee sheet 13b will be protruded from the attachment surface 13d downwardly. And, when the squeegee sheet 13b is protruded downwardly from the attachment surface 13d, as apparent from the sectional view of Fig. 1, it is feared that the recording medium 4 is interfered with the protruded squeegee sheet 13b.

Further, if the squeegee sheet 13b is attached to the curved attachment surface 13d, as shown in Fig. 24A, the both-sided adhesive tape 13e will be protruded from the lower end of the squeegee sheet 13b. Thus, in this condition, when the squeegee sheet 13b is urged against the both-sided adhesive tape 13e by

a sticking tool 21, as shown in Fig. 24B, the protruded portion of the both-sided adhesive tape 13e is stuck to the sticking tool 21, with the result that, when the sticking tool 21 is removed, as shown in Fig. 24C, the both-sided adhesive tape 13e is peeled from the attachment surface 13d, thus causing the poor attachment of the squeegee sheet 13b.

To avoid this, in the illustrated embodiment, as shown in Fig. 25A, the configuration of the lower end of the squeegee sheet 13b becomes substantially the same as the curvature configuration of the attachment surface 13d which has been curved by the pulling tool 20. That is to say, a width of the squeegee sheet 13b is varied from both longitudinal ends to a central portion so that the latter becomes greater than the former (for example, width at the central portion is about 7.9 mm, and width at both ends is about 7.4 mm). In this way, when the squeegee sheet 13b is attached to the attachment surface, the curved both-sided adhesive tape 13e does not protrude from the squeegee sheet 13b. Further, when the pulling tool 20 is removed to release the curvature of the attachment surface 13d thereby to apply the tension to the upper edge of the squeegee sheet 13b as shown in Fig. 25B, the lower end of the squeegee sheet does not protrude from the attachment surface 13d downwardly. Therefore, the above-mentioned interference between the recording medium 4 and the squeegee sheet 13b and the poor attachment of the squeegee sheet 13b can be prevented.

Incidentally, in view of the workability and the service life of a working tool, it is desirable that the lower edge of the squeegee sheet 13b is straight. Thus, as shown in Fig. 26, the width of the squeegee sheet 13b may be varied straightly so that the width at the central portion becomes greater than those at both longitudinal ends in correspondence to the amount of the curvature of the attachment surface 13d. In the above-mentioned embodiment, while the attachment surface 13d was curved by pulling it by the pulling tool 20, it is to be understood that, as shown in Fig. 27, the attachment surface 13d may be curved by pushing toner reservoir partition plates 13c1 integrally formed with the attachment surface 13d by pushing tools 20a.

Further, in the illustrated embodiment, while the squeegee sheet attachment surface 13d was formed on the lower portion of the waste toner reservoir 13c, the squeegee sheet 13b may be stuck to a metallic plate attachment surface independently formed from the waste toner reservoir 13c and then metallic plate may be incorporated into the waste toner reservoir 13c.

Incidentally, in the illustrated embodiment, the squeegee sheet 13b is made of polyethylene terephthalate (PET) and has a thickness of about 38  $\mu$ m, a length of about 241.3 mm, a central width of about 7.9 mm, end widths of about 7.4 mm and an appropriate

radius of curvature of about 14556.7 mm.

#### (Upper and Lower Frames)

Next, the upper and lower frames 14, 15 constituting the housing of the process cartridge B will be explained. As shown in Figs. 7 and 8, the photosensitive drum 9, the developing sleeve 12d and developing blade 12e of the developing means 12, the cleaning means 13 are provided in the lower frame 15. On the other hand, as shown in Figs. 7 and 9, the charger roller 10, the toner reservoir 12a of the developing means 12 and the toner feed mechanism 12b are provided in the upper frame 14.

In order to assemble the upper and lower frames 14, 15 together, four pairs of locking pawls 14a are integrally formed with the upper frame 14 and are spaced apart from each other equidistantly in a longitudinal direction of the upper frame. Similarly, locking openings 15a and locking projections 15b for engaging by the locking pawls 14a are integrally formed on the lower frame 15. Accordingly, when the upper and lower frames 14, 15 are forcibly urged against each other to engage the locking pawls 14a by the corresponding locking openings 15a and locking projections 15b, the upper and lower frames 14, 15 are interconnected. Incidentally, in order to ensure the interconnection between the upper and lower frames, as shown in Fig. 8, a locking pawl 15c and a locking opening 15d are formed near both longitudinal ends of the lower frame 15, respectively, whereas, as shown in Fig. 9, a locking opening 14b (to be engaged by the locking pawl 15c) and a locking pawl 14c (to be engaged by the locking opening 15d) are formed near both longitudinal ends of the upper frame 14, respectively.

When the parts constituting the process cartridge B are separately contained within the upper and lower frames 14, 15 as mentioned above, by arranging the parts which should be positioned with respect to the photosensitive drum 9 (for example, developing sleeve 12d, developing blade 12e and cleaning blade 13a) within the same frame (lower frame 15 in the illustrated embodiment), it is possible to ensure the excellent positioning accuracy of each part and to facilitate the assembling of the process cartridge B. Further, as shown in Fig. 8, fitting recesses 15n are formed in the lower frame 15 in the vicinity of one lateral edge thereof. On the other hand, as shown in Fig. 9, fitting projections 14h (to be fitted into the corresponding fitting recesses 15n) are formed on the upper frame 14 in the vicinity of one lateral edge thereof at intermediate locations between the adjacent locking pawls 14a.

Further, in the illustrated embodiment, as shown in Fig. 8, fitting projections 15e are formed on the lower frame 15 near two corners thereof, whereas fitting recesses 15f are formed in the lower frame near the

other two corners. On the other hand, as shown in Fig. 9, fitting recesses 14d (to be engaged by the corresponding fitting projections 15e) are formed in the upper frame 14 near two corners thereof, whereas fitting projections 14e (to be fitted into the corresponding fitting recesses 15f) are formed in the lower frame near the other two corners. Accordingly, when the upper and lower frames 14, 15 are interconnected, by fitting the fitting projections 14h, 14e, 15e (of the upper and lower frames 14, 15) into the corresponding fitting recesses 15n, 15f, 14d, the upper and lower frames 14, 15 are firmly interconnected to each other so that, even if a torsion force is applied to the interconnected upper and lower frames 14, 15, they are not disassembled.

Incidentally, the positions of the above-mentioned fitting projections and fitting recesses may be changed so long as the interconnected upper and lower frames 14, 15 are not disassembled by any torsion force applied thereto.

Further, as shown in Fig. 9, a protection cover 22 is rotatably mounted on the upper frame 14 via pivot pins 22a. The protection cover 22 is biased toward a direction shown by the arrow h in Fig. 9 by torsion coil springs (not shown) arranged around the pivot pins 22a, so that the projection cover 22 closes or covers the photosensitive drum 9 in the condition that the process cartridge B is removed from the image forming apparatus A as shown in Fig. 4.

More specifically, as shown in Fig. 1, the photosensitive drum 9 is so designed that it is exposed from an opening 15g formed in the lower frame 15 to be opposed to the transfer roller 6 in order to permit the transferring of the toner image from the photosensitive drum onto the recording medium 4. However, in the condition that the process cartridge B is removed from the image forming apparatus A, if the photosensitive drum 9 is exposed to the atmosphere, it will be deteriorated by the ambient light and the dirt and the like will be adhered to the photosensitive drum 9. To avoid this, when the process cartridge B is dismounted from the image forming apparatus A, the opening 15g is closed by the protection cover 22, thereby protecting the photosensitive drum 9 from the ambient light and dirt. Incidentally, when the process cartridge B is mounted within the image forming apparatus A, the protection cover 22 is rotated by a rocking mechanism (not shown) to expose the photosensitive drum 9 from the opening 15g.

Further, as apparent from Fig. 1, in the illustrated embodiment, the lower surface of the lower frame 15 also acts as a guide for conveying the recording medium 4. The lower surface of the lower frame is formed as both side guide portions 15h1 and a stepped central guide portion 15h2 (Fig. 6). The longitudinal length (i.e., distance between the steps) of the central guide portion 15h2 is about 102 - 120 mm (107 mm in the illustrated embodiment) which is slightly

greater than a width (about 100 mm), and the depth of the step is selected to have a value of about 0.8 - 2 mm. With this arrangement, the central guide portion 15h2 increases the conveying space for the recording medium 4, with the result that, even when thicker and resilient sheet such as a post card, visiting card or envelope is used as the recording medium 4, such thicker sheet does not interfere with the guide surface of the lower frame 15, thereby preventing the recording medium from jamming. On the other hand, when a thin sheet having a greater width than that of the post card such as a plain sheet is used as the recording medium, since such sheet (recording medium) is guided by the both side guide portions 15h1, it is possible to convey the sheet without floating.

Now, the lower surface of the lower frame 15 acting as the convey guide for the recording medium will be described more concretely. As shown in Fig. 28, the both side guide portions 15h1 can be flexed by an amount  $L_a$  ( $= 5 - 7$  mm) with respect to a tangential direction X regarding a nip N between the photosensitive drum 9 and the transfer roller 6. Since the both side guide portions 15h1 are formed on the lower surface of the lower frame 15 designed to provide the required space between the lower frame and the developing sleeve 12d and the required space for sufficiently supplying the toner to the developing sleeve, such guide portions are determined by the position of the developing sleeve 12d selected to obtain the optimum developing condition. If the lower surfaces of the side guide portions are approached to the tangential line X, the thickness of the lower portion of the lower frame 15 is decreased, thus causing a problem regarding the strength of the process cartridge B.

Further, the position of a lower end 13f of the cleaning means 13 is determined by the positions of the cleaning blade 13a, the squeegee sheet 13b and the like constituting the cleaning means 13 as described later, and is so selected to provide a distance  $L_b$  ( $= 3 - 5$  mm) preventing the interference with the recording medium 4 being fed. Incidentally, in the illustrated embodiment, as angle  $\beta$  between a vertical line passing through the rotational center of the photosensitive drum 9 shown in Fig. 28 and a line connecting the rotational center of the photosensitive drum and the rotational center of the transfer roller 6 is selected to have a value of 5 - 20 degrees.

In consideration of the above affairs, by providing the recess or step having a depth  $L_c$  ( $= 1 - 2$  mm) only in the central guide portion 15h2 to approach this guide portion to the tangential line X, it is possible to feed the thicker and resilient recording medium 4 smoothly without reducing the strength of the lower frame 15. Incidentally, in most cases, since the thicker and resilient recording medium 4 is the visiting card, envelope or the like which is narrower than the post card under the general specification of the image forming apparatus, so long as the width of the step-

ped or recessed central guide portion 15h2 is selected to be slightly greater than that of the post card, there is no problem in the practical use.

Further, regulating projections 15i protruding downwardly are formed on the outer surface of the lower frame 15 in areas outside of the recording medium guiding zone. The regulating projections 15i each protrudes from the guide surface of the lower frame for the recording medium 4 by about 1 mm. With this arrangement, even if the process cartridge B is slightly lowered for some reason during the image forming operation, since the regulating projections 15i are abutted against a lower guide member 23 (Fig. 1) of the body 16 of the image forming apparatus, the further lowering of the process cartridge can be prevented. Accordingly, a space of at least 1 mm is maintained between the lower guide member 23 and the lower guide surface of the lower frame 15 to provide a convey path for the recording medium 4, thereby conveying the recording medium without jamming. Further, as shown in Fig. 1, a recess 15j is formed in the lower surface of the lower frame 15 not to interfere with the regist roller 5c2. Thus, when the process cartridge B is mounted within the image forming apparatus A, since it can be mounted near the regist roller 5c2, the whole image forming apparatus can be small-sized.

#### (Assembling of Process Cartridge)

Next, the assembling of the process cartridge having the above-mentioned construction will be explained. In Fig. 29, toner leak preventing seals S having a regular shape and made of Moltopren (flexible polyurethane, manufactured by INOAC Incorp.) rubber for preventing the leakage of toner are stuck on ends of the developing means 12 and of the cleaning means 13 and on the lower frame 15. Incidentally, the toner leak preventing seals S each may not have the regular shape. Alternatively, toner leak preventing seals may be attached by forming recesses in portions (to be attached) of the seals and by pouring liquid material which becomes elastomer when solidified into the recesses.

A blade support member 12e1 to which the developing sleeve 12e is attached and a blade support member 13a1 to which the cleaning blade 13a is attached are attached to the lower frame 15 by pins 24a, 24b, respectively. According to the illustrated embodiment, as shown by the phantom lines in Fig. 29, the attachment surfaces of the blade support members 12e1, 13a1 may be substantially parallel to each other so that the pins 24a, 24b can be driven from the same direction. Thus, when a large number of process cartridges B are manufactured, the developing blades 12e and the cleaning blades 13a can be continuously attached by the pins by using an automatic device. Further, the assembling ability for the



blades 12e, 13a can be improved by providing a space for a screw driver, and the shape of a mold can be simplified by aligning the housing removing direction from the mold, thereby achieving the cost-down.

Incidentally, the developing blade 12e and the cleaning blade 13a may not be attached by the pins (screws), but may be attached to the lower frame 15 by adhesives 24c, 24d as shown in Fig. 30. Also in this case, when the adhesives can be applied from the same direction, the attachment of the developing blade 12e and the cleaning blade 13a can be automatically and continuously performed by using an automatic device.

After the blades 12e, 13a have been attached as mentioned above, the developing sleeve 12d is attached to the lower frame 15. Then, the photosensitive drum 9 is attached to the lower frame 15. To this end, in the illustrated embodiment, guide members 25a, 25b are attached to surfaces (opposed to the photosensitive drum) of the blade support members 12e1, 13a1, respectively, at zones outside of the longitudinal image forming area C (Fig. 32) of the photosensitive drum 9. (Incidentally, in the illustrated embodiment, the guide members 25a, 25b are integrally formed with the lower frame 15). A distance between the guide members 25a and 25b is set to be greater than the outer diameter D of the photosensitive drum 9. Thus, after the various parts such as the developing blade 12e, cleaning blade 13a and the like have been attached to the lower frame 15, as shown in Fig. 31, the photosensitive drum 9 can be finally attached to the lower frame while guiding the both longitudinal ends (outside of the image forming area) of the photosensitive drum by the guide members 25a, 25b. That is to say, the photosensitive drum 9 is attached to the lower frame 15 while slightly flexing the cleaning blade 13a and/or slightly retarding and rotating the developing sleeve 12d.

If the photosensitive drum 9 is firstly attached to the lower frame 15 and then the blades 12e, 13a and the like are attached to the lower frame, it is feared that the surface of the photosensitive drum 9 is damaged during the attachment of the blades 12e, 13a and the like. Further, during the assembling operation, it is difficult or impossible to check the attachment positions of the developing blade 12e and the cleaning blade 13a and to measure the contacting pressures between the blades and the photosensitive drum. In addition, although lubricant must be applied to the blades 12e, 13a to prevent the increase in torque and/or the blade turn-up due to the close contact between the initial blades 12e, 13a (at the non-toner condition) and the photosensitive drum 9 and the developing sleeve 12d before the blades 12e, 13a are attached to the lower frame 15, such lubricant is likely to be dropped off from the blades during the assembling of the blades. However, according to the illustrated embodiment, since the photosensitive

drum 9 is finally attached to the lower frame, the above-mentioned drawbacks and problems can be eliminated.

As mentioned above, according to the illustrated embodiment, it is possible to check the attachment positions of the developing means 12 and the cleaning means 13 in the condition that these means 12, 13 are attached to the frames, and to prevent the image forming area of the photosensitive drum from being damaged or scratched during the assembling of the drum. Further, since it is possible to apply the lubricant to the blades in the condition that these means 12, 13 are attached to the frames, the dropping of the lubricant can be prevented, thereby preventing the occurrence of the increase in torque and/or the blade turn-up due to the close contact between the developing blade 12e and the developing sleeve 12d, and the cleaning blade 13a and the photosensitive drum 9.

Incidentally, in the illustrated embodiment, while the guide members 25a, 25b were integrally formed with the lower frame 15, as shown in Fig. 33, projections 12e2, 13a2 may be integrally formed on the blade support members 12e1, 13a1 or other guide members may be attached to the blade support members at both longitudinal end zones of the blade support members outside of the image forming area of the photosensitive drum 9, so that the photosensitive drum 9 is guided by these projections or other guide members during the assembling of the drum.

After the developing sleeve 12d, developing blade 12e, cleaning blade 13a and photosensitive drum 9 have been attached to the lower frame 15 as mentioned above, as shown in Fig. 34 (perspective view) and Fig. 35 (sectional view), the bearing member 26 is incorporated to rotatably support one ends of the photosensitive drum 9 and of the developing sleeve 12d. The bearing member 26 is made of anti-wear material such as polyacetal and comprises a drum bearing portion 26a to be fitted on the photosensitive drum 9, a sleeve bearing portion 26b to be fitted on the outer surface of the developing sleeve 12d, and a D-cut hole portion 26c to be fitted on an end of a D-cut magnet 12c. Alternatively, the sleeve bearing portion 26b may be fitted on the outer surface of the sleeve bearing 12i supporting the outer surface of the developing sleeve 12d or may be fitted between slide surfaces 15Q of the lower frame 15 which are fitted on the outer surface of the slide bearing 12i.

Accordingly, when the drum bearing portion 26a is fitted on the end of the photosensitive drum 9 and the end of the magnet 12c is inserted into the D-cut hole portion 26c and the developing sleeve 12d is inserted between into the sleeve bearing portion 26b and the bearing member 26 is fitted into the side of the lower frame 15 while sliding it in the longitudinal direction of the drum, the photosensitive drum 9 and the developing sleeve 12d are rotatably supported.



Incidentally, as shown in Fig. 34, the earthing contact 18a is attached to the bearing member 26, and, when the bearing member 26 is fitted into the side of the lower frame, the earthing contact 18a is contacted with the aluminium drum core 9a of the photosensitive drum 9 (see Fig. 10). Further, the developing bias contact 18b is also attached to the bearing member 26, and, when the bearing member 26 is attached to the developing sleeve 12d, the bias contact 18b is contacted with a conductive member 18d contacting the inner surface of the developing sleeve 12d.

In this way, by rotatably supporting the photosensitive drum 9 and the developing sleeve 12d by the single bearing member 26, it is possible to improve the positional accuracy of the elements 9, 12d, and to reduce the number of parts, thereby facilitating the assembling operation and achieving the cost-down. Further, since the positioning of the photosensitive drum 9 and the positioning of the developing sleeve 12d and the magnet 12c can be performed by using the single member, it is possible to determine the positional relation between the photosensitive drum 9 and the magnet 12c with high accuracy, with the result that it is possible to maintain a magnetic force regarding the surface of the photosensitive drum 9 constant, thus obtaining the high quality image. In addition, since the earthing contact 18a for earthing the photosensitive drum 9 and the developing bias contact 18b for applying the developing bias to the developing sleeve 12d are attached to the bearing member 26, the compactness of the parts can be achieved effectively, thus making the process cartridge B small-sized effectively.

Further, by providing (on the bearing member 26) supported portions for positioning the process cartridge B within the image forming apparatus when the process cartridge is mounted within the image forming apparatus, the positioning of the process cartridge B regarding the image forming apparatus can be effected accurately. Furthermore, as apparent from Figs. 5 and 6, an outwardly protruding U-shaped projection, i.e., drum shaft portion 26d (Fig. 20) is also formed on the bearing member 26. When the process cartridge B is mounted within the body 16 of the image forming apparatus, the drum shaft portion 26d is supported by a shaft support member 34 as will be described later, thereby positioning the process cartridge B. In this way, since the process cartridge B is positioned by the bearing member 26 for directly supporting the photosensitive drum 9 when the cartridge is mounted within the apparatus body 16, the photosensitive drum 9 can be accurately positioned regardless of the manufacturing and/or assembling errors of other parts.

Further, as shown in Fig. 35, the other end of the magnet 12c is received in an inner cavity formed in the sleeve gear 12k, and an outer diameter of the magnet 12c is so selected as to be slightly smaller

than an inner diameter of the cavity. Thus, at the sleeve gear 12k, the magnet 12c is held in the cavity with any play and is maintained in a lower position in the cavity by its own weight or is biased toward the blade support member 12e1 made of magnetic metal such as ZINKOTE (zinc plated steel plate, manufactured by shin Nippon Steel Incorp.) by a magnetic force of the magnet 12c. In this way, since the sleeve gear 12k and the magnet 12c are associated with each other with any play, the friction torque between the magnet 12c and the rotating sleeve gear 12k can be reduced, thereby reducing the torque regarding the process cartridge.

On the other hand, as shown in Fig. 31, the charger roller 10 is rotatably mounted within the upper frame 14, and the shutter member 11b, the protection cover 22 and the toner feed mechanism 12b are also attached to the upper frame 15. The opening 12a1 for feeding out the toner from the toner reservoir 12a to the developing sleeve 12d is closed by a cover film 28 (Fig. 36) having a tear tape 27. Further, the lid member 12f is secured to the upper frame, and, thereafter, the toner is supplied to the toner reservoir 12a through the filling opening 12a3 and then the filling opening 12a3 is closed by the lid 12a2, thus sealing the toner reservoir 12a.

Incidentally, as shown in Fig. 36, the tear tape 27 of the cover film 28 stuck around the opening 12a1 extends from one longitudinal end (right end in Fig. 36) of the opening 12a1 to the other longitudinal end (left end in Fig. 36) and is bent at the other end and further extends along a gripper portion 14f formed on the upper frame 14 and protrudes therefrom outwardly.

Next, the process cartridge B is assembled by interconnecting the upper and lower frames 14, 15 via the above-mentioned locking pawls and locking openings or recesses. In this case, as shown in Fig. 37, the tear tape 27 is exposed between the gripper portion 14f of the upper frame 14 and a gripper portion 15k of the lower frame 15. Therefore, when a new process cartridge B is used, the operator pulls a protruded portion of the tear tape 27 exposed between the gripper portions 14f, 15k to peel the tear tape 27 from the cover film 28 so as to open the opening 12a1, thus permitting the movement of the toner in the toner reservoir 12a toward the developing sleeve 12d. Thereafter, the process cartridge is mounted within the image forming apparatus A.

As mentioned above, by exposing the tear tape 27 between the gripper portions 14f, 15k of the upper and lower frames 14, 15, the tear tape 27 can easily be exposed from the process cartridge in assembling the upper and lower frames 14, 15. The gripper portions 14f, 15k are utilized when the process cartridge B is mounted within the image forming apparatus. Thus, if the operator forgets to remove the tear tape 27 before the process cartridge is mounted within the

image forming apparatus, since he must grip the gripper portions in mounting the process cartridge, he will know the existence of the non-removed tear tape 27. Further, when the color of the tear tape 27 is clearly differentiated from the color of the frames 14, 15 (for example, if the frames are black, a white or yellow tear tape 27 is used), the noticeability is improved, thus reducing the missing of the removal of the tear tape.

Further, for example, when a U-shaped guide rib for temporarily holding the tear tape 27 is provided on the gripper portion 14f of the upper frame 14, it is possible to surely and easily expose the tear tape 27 at a predetermined position during the interconnection between the upper and lower frames 14, 15. Incidentally, when the process cartridge B is assembled by interconnecting the upper and lower frames 14, 15, since the recess 15j for receiving the regist roller 5c2 is formed in the outer surface of the lower frame 15, as shown in Fig. 38, the operator can surely grip the process cartridge B by inserting his fingers into the recess 15j. Further, in the illustrated embodiment, as shown in Fig. 6, slip preventing ribs 14i are formed on the process cartridge B so that, when the operator can easily grip the process cartridge by hooking his fingers against the ribs. Incidentally, since the recess for receiving (preventing the contact with) the regist roller 5c2 is formed in the lower frame 15 of the process cartridge B, it is possible to make the image forming apparatus more small-sized.

Further, as shown in Fig. 6 since the recess 15j is formed along and in the vicinity of the locking pawls 14a and the locking openings 15b through which the upper and lower frames 14, 15 are interconnected, when the operator grips the process cartridge B by hooking his fingers against the recess 15j, the gripping force from the operator acts toward the locking direction, thus surely interlocking the locking pawls 14a and the locking openings 15b.

Now, the assembling and shipping line for the process cartridge B will be explained with reference to Fig. 39A. As shown, the various parts are assembled in the lower frame 15, and then, the lower frame into which the various parts are incorporated is checked (for example, the positional relation between the photosensitive drum 9 and the developing sleeve 12d is checked). Then, the lower frame 15 is interconnected to the upper frame 14 within which the parts such as the charger roller 10 are assembled, thereby forming the process cartridge B. Thereafter, the total check of the process cartridge B is effected, and then the process cartridge is shipped. Thus, the assembling and shipping line is very simple.

#### (Mounting of Cartridge)

Next, the construction for mounting the process cartridge B within the image forming apparatus A will be explained.

As shown in Fig. 40, a loading member 29 having a fitting window 29a matched to the contour of the process cartridge B is provided on the upper opening/closing cover 19 of the image forming apparatus A. The process cartridge B is inserted into the image forming apparatus through the fitting window 29a by gripping the gripper portions 14f, 15k. In this case, a guide ridge 31 formed on the process cartridge B is guided by a guide groove (not numbered) formed in the cover 19 and the lower portion of the process cartridge is guided a guide plate 32 having a hook at its free end.

Incidentally, as shown in Fig. 40, a miss-mount preventing projection 30 is formed on the process cartridge B and the fitting window 29a has a recess 29b for receiving the projection 30. As shown in Figs. 40 and 41, the configuration or position of the projection 30 is differentiated depending upon a particular process cartridge containing the toner having the developing sensitivity suitable to a particular image forming apparatus A (i.e. differentiated for each process cartridge), so that, even when a process cartridge containing the toner having the different developing sensitivity is tried to be mounted within the particular image forming apparatus, since the projection 30 does not match with the fitting window 29a of that image forming apparatus, it cannot be mounted within that image forming apparatus. Accordingly, the miss-mounting of the process cartridge B can be prevented, thus preventing the formation of the obscure image due to the different developing sensitive toner. Incidentally, it is also possible to prevent the miss-mounting of a process cartridge including a different kind of photosensitive drum, as well as the different developing sensitivity. Further, since the recess 29b and the projection 30 are situated this side when the process cartridge is mounted, if the operator tries to erroneously mount the process cartridge within the image forming apparatus, he can easily ascertain with his eyes the fact that the projection 30 is blocked by the filling member 29. Thus, the possibility that the operator forcibly push the process cartridge into the image forming apparatus to damage the process cartridge B and/or the image forming apparatus A as in the conventional case can be avoided.

After the process cartridge B is inserted into the fitting window 29a of the opening/closing cover 19, when the cover 19 is closed, the rotary shaft 9f of the photosensitive drum 9 which is protruded from one side of the upper and lower frames 14, 15 is supported by a shaft support member 33 (Fig. 40) via a bearing 46a, and the rotary shaft 12d2 of the developing sleeve 12d which is protruded from one side of the upper and lower frames 14, 15 is supported by the shaft support member 33 via a slide bearing 46b and a bearing 46c (Fig. 35). On the other hand, the drum shaft portion 26d (Fig. 35) of the bearing member 26 attached to the other end of the photosensitive drum

9 is supported by a shaft support member 34 shown in Fig. 42.

In this case, the protection cover 22 is rotated to expose the photosensitive drum 9, with the result that the photosensitive drum 9 is contacted with the transfer roller 6 of the image forming apparatus A. Further, the drum earthing contact 18a contacting the photosensitive drum 9, the developing bias contact 18b contacting the developing sleeve 12d and the charging bias contact 18c contacting the charger roller 10 are provided on the process cartridge B so that these contacts protrude from the lower surface of the lower frame 15, and these contacts 18a, 18b, 18c are urgingly contacted with the drum earthing contact pin 35a, developing bias contact pin 35b and charging bias contact pin 35c (Fig. 42), respectively.

As shown in Fig. 42, these contact pins 35a, 35b, 35c are arranged so that the drum earthing contact pin 35a and the charging bias contact pin 35c are disposed at a downstream side of the transfer roller 6 in the recording medium feeding direction and the developing bias contact pin 35b is disposed at an upstream side of the transfer roller 6 in the recording medium feeding direction. Accordingly, as shown in Fig. 43, the contacts 18a, 18b, 18c provided on the process cartridge B are similarly arranged so that the drum earthing contact 18a and the charging bias contact 18c are disposed at a downstream side of the photosensitive drum 9 in the recording medium feeding direction and the developing bias contact 18b is disposed at an upstream side of the photosensitive drum 9 in the recording medium feeding direction.

Now, the disposition of the electric contacts of the process cartridge B will be explained with reference to Fig. 51. Incidentally, Fig. 51 is a schematic plan view showing the positional relation between the photosensitive drum 9 and the electric contacts 18a, 18b, 18c.

As shown in Fig. 51, the contacts 18a, 18b, 18c are disposed at the end of the photosensitive drum 9 opposite to the end where the flange gear 9c is arranged in the longitudinal direction of the drum. The developing bias contact 18b is disposed at one side of the photosensitive drum 9 (i.e. side where the developing means 12 is arranged), and the drum earthing contact 18a and the charging bias contact 18c are disposed at the other side of the photosensitive drum (where the cleaning means 13 is arranged). The drum earthing contact 18a and the charging bias contact 18c are substantially arranged on a straight line. Further, the developing bias contact 18b is arranged slightly outwardly of the positions of the drum earthing contact 18a and the charging bias contact 18c in the longitudinal direction of the photosensitive drum 9. The drum earthing contact 18a, the developing bias contact 18b and the charging bias contact 18c are spaced apart from the outer peripheral surface of the photosensitive drum 9 gradually in order (i.e. a

distance between the contact 18a and the drum is smallest, and a distance between the contact 18c and the drum is greatest). Further, an area of the developing bias contact 18b is greater than an area of the drum earthing contact 18a and an area of the charging bias contact 18c. Furthermore, the developing bias contact 18b, the drum earthing contact 18a and the charging bias contact 18c are disposed outwardly of a position where the arm portions 18a3 of the drum earthing contact 18a are contacted with the inner surface of the photosensitive drum 9, in the longitudinal direction of the photosensitive drum 9.

As mentioned above, by arranging the electric contacts between the process cartridge (which can be mounted within the image forming system) and the image forming apparatus at the positioning and abutting side of the process cartridge, it is possible to improve the positional accuracy between the contacts of the process cartridge and the contact pins of the image forming apparatus, thereby preventing the poor electrical connection, and, by arranging the contacts at the non-driving side of the process cartridge, it is possible to make the configurations of the contact pins of the image forming apparatus simple and small-sized.

Further, since the contacts of the process cartridge are disposed inside of the contour of the frames of the process cartridge, it is possible to prevent foreign matters from adhering to the contacts, and, thus, to prevent the corrosion of the contacts; and, further to prevent the deformation of the contacts due to the external force. Further, since the developing bias contact 18b is arranged at the side of the developing means 12 and the drum earthing contact 18a and the charging bias contact 18c are arranged at the side of the cleaning means 13, the arrangement of electrodes in the process cartridge can be simplified, thus making the process cartridge small-sized.

Now, dimensions of various parts in the illustrated embodiment will be listed up herein below. However, it should be noted that these dimensions are merely an example, and the present invention is not limited to this example:

- (1) Distance (X1) between the photosensitive drum 9 and the drum earthing contact 18a about 6.0 mm;
- (2) Distance (X2) between the photosensitive drum 9 and the charging bias contact 18c about 18.9 mm;
- (3) Distance (X3) between the photosensitive drum 9 and the developing bias contact 18b about 13.5 mm;
- (4) Width (Y1) of the charging bias contact 18c about 4.9 mm;
- (5) Length (Y2) of the charging bias contact 18c about 6.5 mm;
- (6) Width (Y3) of the drum earthing contact 18a about 5.2 mm;

- (7) Length (Y4) of the drum earthing contact 18a about 5.0 mm;
- (8) Width (Y5) of the developing bias contact 18a about 7.2 mm;
- (9) Length (Y6) of the developing bias contact 18a about 8.0 mm
- (10) Diameter (Z1) of the flange gear 9c about 28.6 mm;
- (11) Diameter (Z2) of the gear 9i about 26.1 mm;
- (12) Width (Z3) of the flange gear 9c about 6.7 mm;
- (13) Width (Z3) of the gear 9i about 4.3 mm;
- (14) Number of teeth of the flange gear 9c 33; and
- (15) Number of teeth of the gear 9i 30.

Now, the flange gear 9c and the gear 9i will be explained. The gears 9c, 9i comprise helical gears. When the driving force is transmitted from the image forming apparatus to the flange gear 9c, the photosensitive drum 9 mounted in the lower frame 15 with play is subjected to the thrust force to be shifted toward the flange gear 9c, thereby positioning the drum at the side of the lower frame 15.

The gear 9c is used with a process cartridge containing the magnetic toner for forming a black image. When the black image forming cartridge is mounted within the image forming apparatus, the gear 9c is meshed with a gear of the image forming apparatus to receive the driving force for rotating the photosensitive drum 9 and is meshed with a gear of the developing sleeve 12d to rotate the latter. The gear 9i is meshed with a gear connected to the transfer roller 6 of the image forming apparatus to rotate the transfer roller. In this case, the rotational load does not almost act on the transfer roller 6.

Incidentally, the gear 9i is used with a color image forming cartridge containing the non-magnetic toner. When the color image forming cartridge is mounted within the image forming apparatus, the gear 9c is meshed with the gear of the image forming apparatus to receive the driving force for rotating the photosensitive drum 9. On the other hand, the gear 9i is meshed with the gear connected to the transfer roller 6 of the image forming apparatus to rotate the transfer roller and is meshed with the gear of the developing sleeve 12d for the non-magnetic toner to rotate the latter. The flange gear 9c has a diameter greater than that of the gear 9i, a width greater than that of the gear 9i and a number of teeth greater than that of the gear 9i. Thus, even when the greater load is applied to the gear 9c, the gear 9c can receive the driving force to rotate the photosensitive drum 9 more surely, and can transmit the greater driving force to the developing sleeve 12d for the magnetic toner to rotate the latter more surely.

Incidentally, as shown in Fig. 43, each of the con-

tact pins 35a - 35c is held in a corresponding holder cover 36 in such a manner that it can be shifted in the holder cover but cannot be detached from the holder cover. Each contact pin 35a - 35c is electrically connected to a wiring pattern printed on an electric substrate 37 to which the holder covers 36 are attached, via a corresponding conductive compression spring 38. Incidentally, the charging bias contact 18c to be abutted against the contact pin 35c has the arcuated curvature in the vicinity of the pivot axis 19b of the upper opening/closing cover 19 so that, the opening/closing cover 19 mounting the process cartridge B thereon is rotated around the pivot axis 19b in a direction shown by the arrow R to close the cover, the charging bias contact 18c nearest to the pivot axis 19b (i.e. having the minimum stroke) can contact with the contact pin 35c effectively.

#### (Positioning)

When the process cartridge B is mounted and the opening/closing cover 19 is closed, the positioning is established so that a distance between the photosensitive drum 9 and the lens unit 1c and a distance between the photosensitive drum 9 and the original glass support 1a are kept constant. Such positioning will now be explained.

In shown in Fig. 8, positioning projections 15m are formed on the lower frame 15 to which the photosensitive drum 9 is attached, in the vicinity of both longitudinal ends of the frame. As shown in Fig. 5, when the upper and lower frames 14, 15 are interconnected, these projections 15m protrude upwardly through holes 14g formed in the upper frame 14.

Further, as shown in Fig. 44, the lens unit 1c containing therein the lens array 1c2 for reading the original 2 is attached to the upper opening/closing cover 19 (on which the process cartridge B is mounted) via a pivot pin 1c3 for slight pivotal movement around the pivot pin and is biased downwardly (Fig. 44) by an urging spring 39. Thus, when the process cartridge B is mounted on the upper cover 19 and the latter is closed, as shown in Fig. 44, the lower surface of the lens unit 1c is abutted against the positioning projections 15m of the process cartridge B. As a result, when the process cartridge B is mounted within the image forming apparatus A, the distance between the lens array 1c2 in the lens unit 1c and the photosensitive drum 9 mounted on the lower frame 15 is accurately determined, so that the light image optically read from the original 2 can be accurately illuminated onto the photosensitive drum 9 via the lens array 1c2.

Further, as shown in Fig. 45, positioning pegs 40 are provided in the lens unit 1c, which positioning pegs can be protruded slightly from the upper cover 19 upwardly through holes 19c formed in the upper cover. As shown in Fig. 46, the positioning pegs 40 are protruded slightly at both longitudinal sides of an

original reading slit Z (Figs. 1 and 46). Thus, when the process cartridge B is mounted on the upper cover 19 and the latter is closed and then the image forming operation is started, as mentioned above, since the lower surface of the lens unit 1c is abutted against the positioning projections 15m, the original glass support 1a is shifted while riding on the positioning pegs 40. As a result, a distance between the original 2 rested on the original glass support 1a and the photosensitive drum 9 mounted on the lower frame 15 is always kept constant, thus illuminating the light reflected from the original 2 onto the photosensitive drum 9 accurately. Therefore, since the information written on the original 2 can be optically read accurately and the exposure to the photosensitive drum 9 can be effected accurately, it is possible to obtain the high quality image.

#### (Drive Transmission)

Next, the driving force transmission to the photosensitive drum 9 in the process cartridge B mounted within the image forming apparatus A will be explained.

When the process cartridge B is mounted within the image forming apparatus A, the rotary shaft 9f of the photosensitive drum 9 is supported by the shaft support member 33 of the image forming apparatus as mentioned above. As shown in Fig. 47, the shaft support member 33 comprises a supporting portion 33a for the drum rotary shaft 9f, and an abutment portion 33b for the rotary shaft 12d2 of the developing sleeve 12d. An overlap portion 33c having a predetermined overhanging amount L (1.8 mm in the illustrated embodiment) is formed on the supporting portion 33a, thus preventing the drum rotary shaft 9f from floating upwardly. Further, when the drum rotary shaft 9f is supported by the supporting portion 33a, the rotary shaft 12d2 of the developing sleeve is abutted against the abutment-portion 33b, thus preventing the rotary shaft 12d2 from dropping downwardly. Further, when the upper opening/closing cover 19 is closed, positioning projections 15p of the lower frame 15 protruding from the upper frame 14 of the process cartridge B are abutted against an abutment portion 19c of the opening/closing cover 19.

Accordingly, when the driving force is transmitted to the flange gear 9c of the photosensitive drum 9 by driving the drive gear 41 of the image forming apparatus meshed with the flange gear, the process cartridge B is subjected to a reaction force tending to rotate the process cartridge around the drum rotary shaft 9f in a direction shown by the arrow i in Fig. 47. However, since the rotary shaft 12d2 of the developing sleeve is abutted against the abutment portion 33b and the positioning projections 15p of the lower frame 15 protruding from the upper frame 14 are abutted against the abutment portion 19c of the upper

cover, the rotation of the process cartridge B is prevented.

As mentioned above, although the lower surface of the lower frame 15 acts as the guide for the recording medium 4, since the lower frame is positioned by abutting it against the body of the image forming apparatus as mentioned above, the positional relation between the photosensitive drum 9, the transfer roller 6 and the guide portions 15h1, 15h2 for the recording medium 4 is maintained with high accuracy, thus performing the feeding of the recording medium and the image transfer with high accuracy.

During the driving force transmission, the developing sleeve 12d is biased downwardly not only by the rotational reaction force acting on the process cartridge B but also by a reaction force generated when the driving force is transmitted from the flange gear 9c to the sleeve gear 12j. In this case, if the rotary shaft 12d2 of the developing sleeve is not abutted against the abutment portion 33b, the developing sleeve 12d will be always biased downwardly during the image forming operation. As a result, it is feared that the developing sleeve 12d is displaced downwardly and/or the lower frame 15 on which the developing sleeve 12d is mounted is deformed. However, in the illustrated embodiment, since the rotary shaft 12d2 of the developing sleeve is abutted against the abutment portion 33b without fail, the above-mentioned inconvenience does not occur.

Incidentally, as shown in Fig. 20 the developing sleeve 12d is biased against the photosensitive drum 9 by the springs 12j via the sleeve bearings 12i. In this case, the arrangement as shown in Fig. 48 may be adopted to facilitate the sliding movement of sleeve bearings 12i. That is to say, a bearing 12m for supporting the rotary shaft 12d2 of the developing sleeve is held in a bearing holder 12n such a manner that the bearing 12m can slide along a slot 12n1 formed in the bearing holder. With this arrangement, as shown in Fig. 49, the bearing holder 12n is abutted against the abutment portion 33b of the shaft support member 33 and is supported thereby; in this condition, the bearing 12m can be slide along the slot 12n1 in directions shown by the arrow. Incidentally, in the illustrated embodiment, an inclined angle  $\theta$  (Fig. 47) of the abutment portion 33b is selected to have a value of about 40 degrees.

Further, the developing sleeve 12d may be supported, not via the sleeve rotary shaft. For example, as shown in Figs. 52A and 52B, it may be supported at its both ends portions by sleeve bearings 52 lower ends of which are supported by the lower frame 15 which is in turn supported by receiving portions 53 formed on the image forming system.

Further, in the illustrated embodiment, the flange gear 9c of the photosensitive drum 9 is meshed with the drive gear 41 for transmitting the driving force to the flange gear in such a manner that, as shown in

Fig. 47, a line connecting a rotational center of the flange gear 9c and a rotational center of the drive gear 41 is offset from a vertical line passing through the rotational center of the flange gear 9c in an anti-clockwise direction by a small angle  $\alpha$  (about  $1^\circ$  in the illustrated embodiment), whereby a direction F of the driving force transmission from the drive gear 41 to the flange gear 9c directs upwardly. In general, although the floating of the process cartridge can be prevented by a downwardly directing force generated by setting the angle  $\alpha$  to a value of  $20^\circ$  or more, in the illustrated embodiment, such angle  $\alpha$  is set to about  $1^\circ$ .

By setting the above-mentioned angle  $\alpha$  to about  $1^\circ$ , when the upper opening/closing cover 19 is opened in a direction shown by the arrow j to remove the process cartridge B, the flange gear 9c is not blocked by the drive gear 41 and, thus, can be smoothly disengaged from the drive gear 41. Further, when the direction F of the driving force transmission is directed upwardly as mentioned above, the rotary shaft 9f of the photosensitive drum is pushed upwardly and, therefore, tends to be disengaged from the drum supporting portion 33a. However, in the illustrated embodiment, since the overlap portion 33c is formed on the supporting portion 33a, the drum rotary shaft 9f is not disengaged from the drum supporting portion 33a.

#### (Re-cycle)

The process cartridge having the above-mentioned construction permits the re-cycle. That is to say, the used-up process cartridge(s) can be collected from the market and the parts thereof can be re-used to form a new process cartridge. Such re-cycle will now be explained. Generally, the used-up process cartridge was disposed or dumped in the past. However, the process cartridge B according to the illustrated embodiment can be collected from the market after the toner in the toner reservoir has been used up, to protect the resources on the earth and the natural environment. Then, the collected process cartridge is disassembled into the upper and lower frames 14, 15 which are in turn cleaned. Thereafter, reusable parts and new parts are mounted on the upper frame 14 or the lower frame 15 at need, and then new toner is supplied into the toner reservoir 12a again. In this way, a new process cartridge is obtained.

More particularly, by releasing the connections between the locking pawls 14a and the locking openings 15a, the locking pawls 14a and the locking projection 15b, the locking pawl 14c and the locking opening 15d, and the locking pawl 15c and the locking opening 14b (Figs. 4, 8 and 9) which interconnect the upper and lower frames 14, 15, the upper and lower frames 14, 15 can easily be disassembled from

each other. Such disassembling operation can easily be performed, for example, by resting the used-up process cartridge B on a disassembling tool 42 and by pushing the locking pawl 14a by means of a pusher rod 42a, as shown in Fig. 50. Even when the disassembling tool is not used, the process cartridge can be disassembled by pushing the locking pawls 14a, 14c, 15c.

After the upper frame 14 and the lower frame 15 are disconnected from each other as mentioned above (Figs. 8 and 9), the frames are cleaned by removing the waste toner adhered to or remaining in the cartridge by an air blow technique. In this case, a relatively large amount of waste toner is adhered to the photosensitive drum 9, developing sleeve 12d and/or cleaning means 13 since they are directly contacted with the toner. On the other hand, the waste toner is not or almost not adhered to the charger roller 10 since it is not directly contacted with the toner. Accordingly, the charger roller 10 can be cleaned more easily than the photosensitive drum 9, developing sleeve 12d and the like. In this regard, according to the illustrated embodiment, since the charger roller 10 is mounted on the upper frame 14 other than the lower frame 15 on which the photosensitive drum 9, developing sleeve 12d and cleaning means 13 are mounted, the upper frame 14 separated from the lower frame 15 can easily be cleaned.

In the disassembling and cleaning line as shown in Fig. 39B, first of all, the upper and lower frames 14, 15 are separated from each other as mentioned above. Then, the upper frame 14 and the lower frame 15 are disassembled and cleaned independently. Thereafter, as to the upper frame 14, the charger roller 10 is separated from the upper frame and is cleaned; and as to the lower frame 15, the photosensitive drum 9, developing sleeve 12d, developing blade 12e, cleaning blade 13a and the like are separated from the lower frame and are cleaned. Thus, the disassembling and cleaning line is very simple.

After the toner is cleared, as shown in Fig. 9, the opening 12a1 is sealed by a new cover film 28 again, and new toner is supplied into the toner reservoir 12a through the toner filling opening 12a3 formed in the side surface of the toner reservoir 12a, and then the filling opening 12a3 is closed by the lid 12a2. Then, the upper frame 14 and the lower frame 15 are interconnected again by achieving the connections between the locking pawls 14a and the locking openings 15a, the locking pawls 14a and the locking projection 15b, the locking pawl 14c and the locking opening 15d, and the locking pawl 15c and the locking opening 14b, thus assembling a process cartridge again in a usable condition.

Incidentally, when the upper and lower frames 14, 15 are interconnected, although the locking pawls 14a and the locking openings 15a, the locking pawls 14a and, the locking projection 15b and the like are

interlocked, when the same process cartridge is frequently re-cycled, it is feared that the locking forces between the locking pawls and the locking openings become weaker. To cope with this, in the illustrated embodiment, threaded holes are formed in the frames in the vicinity of four corners thereof. That is to say, through threaded holes are formed in the fitting recesses 14d and the fitting projections 14e of the upper frame 14 (Fig. 8) and in the fitting projections 15e (to be fitted into the recesses 14d) and the fitting recesses 15f (to be fitted onto the projections 14e) of the lower frame 15, respectively. Thus, even when the locking force due to the locking pawls become weaker, after the upper and lower frames 14, 15 are interconnected and the fitting projections and fitting recesses are interfitted, by screwing screws in the mated threaded holes, the upper and lower frames 14, 15 can be firmly interconnected.

#### Image forming Operation

Next, the image forming operation effected by the image forming apparatus A within which the process cartridge B is mounted will be explained.

First of all, the original 2 is rested on the original glass support 1a shown in Fig. 1. Then, when the copy start button A3 is depressed, the light source 1c1 is turned ON and the original glass support 1a is reciprocally shifted on the image forming apparatus in the left and right directions in Fig. 1 to read the information written on the original optically. On the other hand, in registration with the reading of the original, the sheet supply roller 5a and the pair of register rollers 5c1, 5c2 are rotated to feed the recording medium 4 to the image forming station. The photosensitive drum 9 is rotated in the direction d in Fig. 1 in registration of the feeding timing of the paired register roller 5c1, 5c2, and is uniformly charged by the charger means 10. Then, the light image read by the reading means 1 is illuminated onto the photosensitive drum 9 via the exposure means 11, thereby forming the latent image on the photosensitive drum 9.

At the same time when the latent image is formed, the developing means 12 of the process cartridge B is activated to drive the toner feed mechanism 12b, thereby feeding out the toner from the toner reservoir 12a toward the developing sleeve 12d and forming the toner layer on the rotating developing sleeve 12d. Then, by applying to the developing sleeve 12d a voltage having the same charging polarity and same potential as that of the photosensitive drum 9, the latent image on the photosensitive drum 9 is visualized as the toner image. In the illustrated embodiment, the voltage of about 1.2 KVVpp, 1590 Hz (rectangular wave) is applied to the developing sleeve 12d. The recording medium 4 is fed between the photosensitive drum 9 and the transfer roller 6. By applying to the transfer roller 6 a voltage having the

polarity opposite to that of the toner, the toner image on the photosensitive drum 9 is transferred onto the recording medium 4. In the illustrated embodiment, the transfer roller 6 is made of foam EPDM having the volume resistance of about  $10^9 \Omega\text{cm}$  and has an outer diameter of about 20 mm, and the voltage of - 3.5 KV is applied to the transfer roller as the transfer voltage.

After the toner image was transferred to the recording medium, the photosensitive drum 9 continues to rotate in the direction d. Meanwhile, the residual toner remaining on the photosensitive drum 9 is removed by the cleaning blade 13a, and the removed toner is collected into the waste toner reservoir 13c via the squeegee sheet 13b. On the other hand, the recording medium 4 on which the toner image was transferred is sent, by the convey belt 5d, to the fixing means 7 where the toner image is permanently fixed to the recording medium 4 with heat and pressure. Then, the recording medium is ejected by the pair of ejector rollers 5f1, 5f2. In this way, the information on the original is recorded on the recording medium.

Next, other embodiments will be explained.

In the above-mentioned first embodiment, while an example that the developing blade 12e and the cleaning blade 13a are attached to the frame by pins 24a, 24b was explained, as shown in Fig. 53, when the developing blade 12e and the cleaning blade 13a are attached to the lower frame 15 by forcibly inserting fitting projections 43a, 43b formed on both longitudinal ends of the developing blade 12e and the cleaning blade 13e into corresponding fitting recesses 44a, 44b formed in the body 16 of the image forming apparatus, pin holes 45 for receiving the pins for attaching the blades 12e, 13a may be formed in the vicinity of the fitting projections 43a, 43b, and corresponding pin holes 45 may be formed in the body 16 of the image forming apparatus (Incidentally, in place of the fitting projections 43a, 43b, half punches or circular bosses may be used).

With this arrangement, when the fitting connections between the blades 12e, 13a and the lower frame are loosened by the repeated re-cycle of the process cartridge B, the blades 12e, 13a can be firmly attached to the lower frame by pins.

Further, in the first embodiment, as shown in Fig. 29, while an example that the outer diameter D of the photosensitive drum 9 is smaller than the distance L between the drum guide members 25a, 25b to permit the final attachment of the photosensitive drum 9 to the lower frame 15 was explained, as shown in Fig. 54, even when the photosensitive drum 9 is incorporated into the upper frame 14, the outer diameter D of the photosensitive drum 9 may be smaller than the distance L between the drum guide members 25a, 25b so that the photosensitive drum can be lastly incorporated into the upper frame, thereby preventing the surface of the photosensitive drum 9 from damaging, as in the first embodiment. Incidentally, in Fig.



54, elements or parts having the same function as those in the first embodiment are designated by the same reference numerals. Further, the upper and lower frames 14, 15 are interconnected by interlocking locking projections 47a and locking openings 47b and by securing them by pins 48.

Further, as shown in Fig. 35, in the first embodiment, while the photosensitive drum 9 and the developing sleeve 12d were supported by the bearing member 26, when the flange gear 9c is provided at one end of the photosensitive drum 9 and the transfer roller gear 49 is provided at the other end of the photosensitive drum, a structure as shown in Fig. 55 may be adopted. Incidentally, also in Fig. 55, elements having the same function as those in the first embodiment are designated by the same reference numerals.

More particularly, in Fig. 55, the flange gear 9c and the transfer roller gear 49 are secured to both ends of the photosensitive drum 9 by adhesive, press-fit or the like, respectively, the positioning of the drum is effected by rotatably supporting a central boss 49a of the transfer roller gear 49 by the bearing portion 33a of the bearing member 26. In this case, in order to earth the photosensitive drum 9, a drum earthing plate 50 having a central L-shaped contact portion is secured to and contacted with the inner surface of the drum, and a drum earthing shaft 51 passing through a central bore in the transfer roller gear 49 is always contacted with the drum earthing plate 50. The drum earthing shaft 51 is made of conductive metal such as stainless steel, and the drum earthing plate 50 is also made of conductive metal such as bronze phosphate, stainless steel or the like. When the process cartridge B is mounted within the image forming apparatus A, a head 51a of the drum earthing shaft 51 is supported by the bearing member 26. In this case, the head 51a of the drum earthing shaft 51 is contacted with the drum earthing contact pin of the image forming apparatus, the earthing the photosensitive drum. Also in this case, as in the first embodiment, the positional accuracy between the photosensitive drum 9 and the developing sleeve 12d can be improved by using the single bearing member 26.

Further, the process cartridge B according to the present invention can be used to not only form a mono-color image as mentioned above, but also form a multi-color image (two color image, three color image or full-color image) by providing a plurality of developing means 12. Furthermore, the developing method may be of known two-component magnetic brush developing type, cascade developing type, touchdown developing type or cloud developing type. In addition, in the first embodiment, while the charger means was of the so-called contact-charging type, for example, other conventional charging technique wherein three walls are formed by tangsten wires and metallic shields made of aluminium are provided on

the three walls, and positive or negative ions generated by applying a high voltage to the tangsten wires are shifted onto the surface of the photosensitive drum 9, thereby uniformly charging the surface of the photosensitive drum 9 may be adopted.

Incidentally, the contact-charging may be, for example, of blade (charging blade) type, pad type, block type, rod type or wire type, as well as the aforementioned roller type. Further, the cleaning means for removing the residual toner remaining on the photosensitive drum 9 may be of fur brush type or magnetic brush type, as well as blade type.

Furthermore, the process cartridge B comprises an image bearing member (for example, an electrophotographic photosensitive member) and at least one process means. Therefore, as well as the above-mentioned construction, the process cartridge may incorporate integrally therein the image bearing member and the charger means as a unit which can be removably mounted within the image forming apparatus; or may incorporate integrally therein the image bearing member and the developing means as a unit which can be removably mounted within the image forming apparatus; or may incorporate integrally therein the image bearing member and the cleaning means as a unit which can be removably mounted within the image forming apparatus; or may incorporate integrally therein the image bearing member and two or more process means as a unit which can be removably mounted within the image forming apparatus. That is to say, the process cartridge incorporates integrally therein the charger means, developing means or cleaning means and the electrophotographic photosensitive member as a unit which can be removably mounted within the image forming apparatus; or incorporates integrally therein at least one of the charger means, developing means and cleaning means, and the electrophotographic photosensitive member as a unit which can be removably mounted within the image forming apparatus; or incorporates integrally therein the developing means and the electrophotographic photosensitive member as a unit which can be removably mounted within the image forming apparatus.

Further, in the illustrated embodiment, while the image forming apparatus was the electrophotographic copying machine, the present invention is not limited to the copying machine, but may be adapted to other various image forming apparatus such as a laser beam printer, a facsimile, a word processor and the like.

Now, the above-mentioned driving force transmission to the photosensitive drum 9 will further explained with more detail. As shown in Fig. 56, the driving force is transmitted from the drive motor 54 attached to the body 16 of the image forming apparatus to a drive gear G6 via a gear train G1 - G5, and from the drive gear G6 to the flange gear 9c meshed with the



drive gear, thereby rotating the photosensitive drum 9. Further, the driving force of the drive motor 54 is transmitted from the gear G4 to a gear train G7 - G11, thereby rotating the sheet supply roller 5a. Furthermore, the driving force of the drive motor 54 is transmitted from the gear G1 to the driving roller 7a of the fixing means 7 via gears G12, G13.

Further, as shown in Figs. 57 and 58, the flange gear (first gear) 9c and the gear (second gear) 9i are integrally formed and portions of the gears 9c, 9i are exposed from an opening 15g formed in the lower frame 15. When the process cartridge B is mounted within the image forming apparatus A, as shown in Fig. 59, the drive gear G6 is meshed with the flange gear 9c of the photosensitive drum 9 and the gear 9i integral with the gear 9c is meshed with the gear 55 of the transfer roller 6. Incidentally, in Fig. 59, the parts of the image forming apparatus are shown by the solid line, and the parts of the process cartridge are shown by the phantom line.

The number of teeth of the gear 9c is different from that of the gear 9i, so that the rotational speed of the developing sleeve 12d when the black image forming cartridge containing the magnetic toner is used is differentiated from the rotational speed of the developing sleeve when the color image forming cartridge containing the non-magnetic toner is used. That is to say, when the black image forming cartridge containing the magnetic toner is mounted within the image forming apparatus, as shown in Fig. 60A, the flange gear 9c is meshed with the sleeve gear 12k of the developing sleeve 12d. On the other hand, when the color image forming cartridge containing the non-magnetic toner is mounted within the image forming apparatus, as shown in Fig. 60B, the gear 9i is meshed with the sleeve gear 12k of the developing sleeve 12d to rotate the developing sleeve.

As mentioned above, since the gear 9c has the greater diameter and wider width than those of the gear 9i and has the number of teeth greater than that of the gear 9i, even when the greater load is applied to the gear 9c, the gear 9c can surely receive the driving force to rotate the photosensitive drum 9 surely and transmits the greater driving force to the developing sleeve 12d for the magnetic toner, thereby surely rotating the developing sleeve 12d.

Next, when the developing blade 12e and the cleaning blade 13a are forcibly fitted into the fitting portions 44a, 44b of the body 16 of the image forming apparatus as shown in Fig. 53, preferred embodiments of a cleaning blade will be explained. Incidentally, hereinbelow, although the cleaning blade 13a will be described, the developing blade 12e can be considered similarly.

Fig. 61 is a perspective view showing a cleaning blade 13a and a fitting portion 44b, and Figs. 62 and 63 are plan views thereof. As shown in Figs. 61 to 63, a tapered portion 43b1 is formed by obliquely cutting

a lower portion of a fitting projection 43b formed on a longitudinal end of the blade supporting member 13a1, and a tapered portion 44b1 is formed by obliquely cutting an upper portion of the fitting portion 44b of the body 16 of the image forming apparatus. Thus, when the fitting projection 43b is being fitted into the fitting portion 44b, by engaging the tapered portions 43b1, 44b1 by each other, the projection 43b can smoothly be inserted into the fitting portion 44b.

Incidentally, as shown in Fig. 63, when the fitting projection 43b fitted into the fitting portion 44b, a lower end 43b2 of the projection 43b is abutted against a lower end 44b2 of the fitting portion 44b, thereby regulating an inserting amount of the cleaning blade 13a. Thus, when the tapered portion 43b1 is formed on the fitting projection 43b, it is preferable that the lower end 43b2 are left.

Further, although the fitting projection 43b is forcibly fitted into the fitting portion 44b as mentioned above when the blade supporting member 13a1 is fitted, in case of the automatic assembling operation, as shown in Fig. 64, the lower frame 15 is pulled by a suitable tool (not shown) in a direction shown by the arrow to elastically deform it so as to increase the distance between the fitting portions 44b, and then, as shown in Fig. 65, the blade supporting member 13a1 is fitted between the fitting portions 44b. In this case, as mentioned above, the fitting operation can be performed smoothly because of the existence of the tapered portions 43b1, 44b1. Then, when the tool is released, as shown in Fig. 66, the deformation of the lower frame 15 is elastically restored, thus fitting the fitting projections 43b into the fitting portions 44b. Further, the fitting portions 44b are pushed in directions shown by the arrows in Fig. 66, thereby interlocking the fitting projections 43b and the fitting portions 44b without fail. In this way, the cleaning blade can easily be assembled.

Further, in place of the inclined tapered portion 43b1 formed on the fitting projection 43b, as shown in Fig. 67, the lower portion of the fitting projection may be rounded to have a certain curvature of radius. Also in this case, the same technical effect can be obtained.

Further, as shown in Fig. 68, the tapered portion 43b1 formed on the fitting projection 43b may be rounded by chamfering a lower portion of the tapered portion 43b1. In this case, the fitting projection can be fitted into the fitting portion 44b more smoothly. Further, even if the tapered portion 43b1 is not formed, when the lower portion of the fitting projection 43b is merely rounded as mentioned above, the fitting smoothness is improved to some extent.

In addition, Fig. 69 shows an embodiment wherein a PTFE tape 13a3 and the like is adhered to the tapered portion 43b1 of the blade supporting member 13a1, thereby permitting the smooth fitting of the projection into the fitting portion of the apparatus body.

Furthermore, Fig. 70 shows another embodiment wherein lubricant 13a4 such as silicone oil, grease and the like is coated on the tapered portion 13b1 to lubricate the tapered portion, thereby improving the smooth fitting of the fitting projection into the fitting portion of the apparatus body.

Incidentally, when the tape 13a3 is adhered to the tapered portion or when the lubricant is coated on the tapered portion, although it is not necessary to form the tapered portion 43b1 in the fitting portion 43b, the tape or lubricant should not be provided on the lower end 43b2 which serves as the positioning reference, in order to maintain the attachment accuracy.

Further, a method for attaching the aforementioned blade will be explained with reference to Figs. 64, 65 and 71A - 75.

By the way, when the blade support member 13a1 is fitted, although the fitting projections 43b are forcibly fitted into the corresponding fitting portions 44b as mentioned above, as shown in Figs. 64, 65 and 71A - 75, the automatic assembling may be effected by using tools 56, 57.

That is to say, as shown in a schematic plan view of Fig. 71A and a schematic front view of Fig. 71B, first of all, the lower frame 15 is rested on a cartridge supporting base 60, and hook portions 56a of tools 56 are locked on the blade fitting portions 44b which constitute a frame for supporting the blade support member 13a1. The hook portions 56a are connected to cylinders 56b which are in turn connected to pumps 56c.

After the hook portions 56a are locked on the blade fitting portions 44b, the pumps 56c are activated to generate a force of about 2 - 6 kgf for widening the distance between the opposed fitting portions 44b, thereby widening the distance between the opposed fitting portions 44b by about 0.5 - 2 mm. As a result, the distance between the fitting portions 44b is widened as shown in Fig. 64, so that the fitting projections 43b of the blade 13 can easily be inserted between the fitting portions 44b as shown in Fig. 65. Incidentally, in this case, the fitting operation is facilitated because of the presence of the aforementioned tapered portions 43b1, 44b1.

After the blade 13 is fitted, as shown in Figs. 72A and 72B, by using a tool 57, a force for making the distance between the opposed fitting portions 44b narrower is generated. The tool 57 used in this embodiment comprises a toggle clamping tool which includes a plate member 57a having a locking hook portion 57a1 at its one end and an upright portion 57b at its other end, which upright portion has a fixed portion 57c secured thereto. An arm 57e, a handle 57f and an operation arm 57g are pivotally mounted on the fixed portion 57c via pivot pins 57d1, 57d2, 57d3, respectively. Now, the hook portion 57a is locked against an outer surface of one of the fitting portions 44b and a locking hole 57a2 formed in the plate member 57 at

a predetermined position is engaged by a projection 15m of the lower frame 15. In this condition, when the handle 57f is rocked toward a direction shown by the arrow in Fig. 72A, the operation arm 57g is rotated, so that, as shown in Fig. 72B, an operation portion 57g1 urges the other fitting portion 44b in a direction shown by the arrow, thereby making the distance between the opposed fitting portions 44b narrower by the locking of the hook portion 57a and the urging of the operation portion 57g1. In this embodiment, by applying the force of about 1 - 4 kgf, the distance between the opposed fitting portions 44b is made narrower by about 0.1 - 1.5 mm.

In this way, as shown in Fig. 73, the abutment portions 44b3 of the fitting portions 44b are abutted against abutment portions 58 of the blade support member 13a1 (refer to a perspective view of the cleaning blade in Fig. 74), thereby maintaining the positional accuracy of the blade support member 13a1 to the lower frame 15. In this way, the fitting projections 43b are fitted into the fitting portions 44b. In this condition, when the blade 13a is secured by threading the screws 59 into the threaded holes 45, the blade 13a is attached in place with high accuracy.

Incidentally, although the lower frame 15 made of plastic material is obtained by injecting synthetic resin into a mold and by picking up the molded part by decomposing the mold, it is feared that the fitting portions 44b are deformed to widen the distance therebetween due to the temperature of the mold and/or the temperature and pressure of the resin being injected. However, even when such deformation occurs, by urging the abutment portions 44b3 of the fitting portions 44b to abut them against the abutment portions 58 of the blade 13a, it is possible to correct such deformation, and, thus, to enhance the dimensional accuracy of the parts. Therefore, the cleaning blade 13a attached to the lower frame 15 can be uniformly urged against the photosensitive drum 9 attached to the lower frame 15 along the whole longitudinal direction of the blade. Similarly, it is possible to accurately maintain the attaching position of the dip sheet 13b attached to the lower frame 15.

Further, when the lower frame 15 is subjected to the force for making the distance between the fitting portions 44b narrower from the direction X by the tool 57, it is subjected to a force by which the lower surface of the lower frame is deflected toward the outside of the cartridge (i.e., direction shown by the arrow Y). Accordingly, when the process cartridge B is gripped by the operator's hand as shown in Fig. 38, if the wall of the lower frame 15 is thin, the lower surface of the lower frame will easily be deflected inwardly, and, in an extreme case, the deflected lower frame will be contacted with the developing sleeve 12d, thus damaging the latter. However, by applying the force by which the lower surface of the lower frame is deflected toward the outside of the cartridge as

mentioned above, it is possible to prevent the inward deflection of the lower frame 15. Accordingly, it is possible to reduce the thickness of the lower frame 15 and to arrange the developing sleeve 12d in the vicinity of the inner surface of the lower frame 15, thereby making the process cartridge B small-sized and light-weighted.

Incidentally, while an example that the cleaning blade 13a is attached was explained, the developing blade 12e may be attached similarly by using the tools 56, 57. In the case, when a developing sleeve 12e shown in Fig. 75 is attached, blade fitting portions formed on the lower frame are abutted against abutment portions 12e3 of a blade support member 12e1. Now, an L-shaped regulating plate 12e4 is attached to the blade support member 12e1. When the toner in the toner reservoir 12a is fed to the developing sleeve 12d or when the toner layer adhered to the developing sleeve 12e is rotated along with the rotation of the developing sleeve 12d, the toner is prevented from entering into a space (refer to Fig. 4) defined between the outer wall of the toner reservoir 12a and the developing blade support member, by the regulating plate 12e4.

As mentioned above, the cleaning blade 13a is attached to the lower frame 15, and then the developing blade 12e is attached to the lower frame. Then, the developing sleeve 12d is attached to the lower frame, and the photosensitive drum 9 is lastly attached to the lower frame.

In this way, in order to abut the fitting portions of the lower frame against both longitudinal ends of the blade support members 13a1, 12e1 of the cleaning blade 13a and the developing blade 12e by reducing the distance between the fitting portions by using the tool 57, it is preferable that the rigidity of the fitting portions is greater than the rigidity of the blade support members. To this end, in the illustrated embodiment, the lower frame 15 may be made of plastic and the blade support members 13a1, 12e1 may be formed from metal (for example, iron or the like) plates. Incidentally, the lower frame 15 is preferably made of polystyrene, acrylonitrile butadiene styrene, polyphenylene oxide, polyphenylene ether or the like.

Further, in the illustrated embodiment, while the elastic blades made of urethane rubber were used as the blades 13a, 12e, when these blades 13a, 12e are made of material having the greater rigidity (such as metal), the fitting portions of the lower frame may be abutted against the blades 13a, 12e directly, instead of the blade support members.

In the illustrated embodiment, the frame is swelled outwardly by applying to the frame the force for reducing the distance between the opposed frames after the blade support member is locked to the locking portions. Thus, even when the wall of the frame is thin, it is difficult to deflect the frame even if the frame is gripped by the operator's hand, thus preventing the

frame from contacting with the developing sleeve, for example.

Further, when the force for reducing the distance between the opposed frames is applied, by abutting both longitudinal ends of the blade support member against the opposed frames, even if the frames are deflected, it is possible to easily maintain the attaching position of the blade with high accuracy.

Method for attaching the cleaning blade 13a and the developing blade 12e will be further described with reference to Figs. 76A to 81. Incidentally, in various embodiments described hereinbelow, since a method for attaching the cleaning blade 13a is the same as a method for attaching the developing blade 12e, only the method for attaching the developing blade 12e will be explained.

As shown in Figs. 76A to 81, protruded portions 62n1 are formed on both longitudinal ends of the developing blade 12e, and a tapered portion 62n2 extending inwardly and downwardly is formed on a lower portion of each protruded portion 62n1.

On the other hand, blade supporting portions 66, 67 are formed on the housing. The supporting portions 66, 67 are formed from elastically deformable material so that the supporting portions can be elastically deformed in directions shown by the arrows B. Further, the supporting portions 66, 67 are hollow and are provided at their lower ends with reference surfaces 66a, 67a and have hold-down portions 66b, 67b at their upper ends. Incidentally, the supporting portions 66, 67 are spaced apart from each other by a distance corresponding to a longitudinal length of the blade 12e, and a distance between the reference surfaces 66a, 67a and the hold-down portions 66b, 67b is slightly smaller than a width (dimension in an up-and-down direction) of the protruded portion 62n1.

Accordingly, as shown in Fig. 76B, when the blade 12e is forcibly inserted toward a direction A, the tapered portions 62n1 are abutted against the hold-down portions 66b, 67b, thus elastically deforming the blade supporting portions 66, 67 toward the directions B. In a condition that the lower ends of the protruded portions 62n1 are abutted against the reference surfaces 66a, 67a, when the blade supporting portions 66, 67 are urged from the outside toward directions C as shown in Fig. 76C, the upper ends of the protruded portions 62n1 are press-fitted into the hold-down portions 66b, 67b (fitted areas D are shown by hatched zones in Figs. 76C and 76D) and are secured, thereby attaching the blade 12e surely.

In this way, the blade 12e can easily be attached only by forcibly inserting the blade 12e while elastically deforming the blade supporting portions 66, 67. Further, since there is no need to secure the blade by screws, it is possible to reduce the number of parts, thus achieving the cost-down.

A further embodiment is shown in Figs. 77A and

77B. In this embodiment, fitting margins 66c, 67c are provided on the inner surfaces of the blade supporting portions 66, 67 (in the illustrated embodiment, three fitting margins are provided). In this embodiment, when the blade 12e is attached, the protruded portions 62n1 are fitted into the blade supporting portions while cutting off the fitting margins 66c, 67c. The fitting margins 66c, 67c may be provided at a single position or at a plurality of positions in dependence upon the size of the protruded portions 62n1 of the blade. With this arrangement, it is possible to reduce the fitting force when the blade 12e is attached, thus improving the operability and the assembling ability.

In the aforementioned embodiment, while the fitting margins were provided on the blade supporting portions 66, 67 in order to reduce the fitting force for the blade 12e, a further embodiment is shown in Figs. 78A and 78B. Incidentally, Fig. 78A is a plan view, and Fig. 78B is a sectional view taken along the line J - J in Fig. 78A.

In this embodiment, tapered portions 66d, 67d (portions 67d are not shown) are formed on the blade supporting portions 66, 67. The tapered portions 66d, 67d define passages in the blade supporting portions 66, 67. Each passage has an inlet opening having a width greater than that of the protruded portion 62n1 of the blade and an outlet opening having a width smaller than that of the protruded portion, and the width of the passage is gradually decreased from the inlet opening to the outlet opening.

With this arrangement, when the blade 12e is attached to the blade supporting portions, the protruded portions 62n1 can easily be inserted into the tapered portions 66d, 67d, and the fitting force can be smaller than that in the previous embodiment.

A still further embodiment is shown in Figs. 79A and 79B. Incidentally, Fig. 79A is a plan view, and Fig. 79B is a sectional view taken along the line K - K in Fig. 78A. Further, in these Figures, only the blade supporting portion 66 is illustrated.

In this embodiment, a fitting bore 62n3 is formed in each protruded portion 62n1, and hinge portions 66e, 67e having projections 66f, 67f are formed on the blade supporting portions 66, 67 (67 is not shown). When the protruded portions 62n1 of the blade are inserted into the blade supporting portions 66, 67, the hinge portions 66e, 67e are elastically deformed so that the projections 66f, 67f formed on the ends of the hinge portions are fitted into the corresponding fitting holes 62n3.

With this arrangement, it is possible to reduce the fitting force when the blade 12e is attached and secured, and to ascertain the positioning of the blade 12e when it is inserted into the supporting portions. Accordingly, the assembling ability is further improved. Incidentally, as in the aforementioned embodiment, when the arrangement wherein the blade is fitted into the blade supporting portions while cut-

ting off the latter is also used in this embodiment, the blade can be secured more surely.

Further embodiments are shown in Figs. 80 and 81. In an embodiment shown in Fig. 80, one of the protruded portions 62n1 is fitted into the blade supporting portion 66 and is supported by it, and the other protruded portion 62n1 is press-fitted into the blade supporting portion 67 while elastically deforming the supporting portion 67 in a direction shown by the arrow. With this arrangement, since the inner surface of only one of the blade supporting portions is required to be cut off when the protruded portions 62n1 of the blade are press-fitted, the assembling ability is still improved.

In an embodiment shown in Fig. 81, one of the protruded portions 62n1 of the blade is fitted into the blade supporting portion 66 and is supported by it. A threaded hole 62n4 is formed in the other protruded portion 62n1. By aligning the threaded hole 62n4 with a threaded hole 67g formed in the blade supporting portion 67 and by threading a screw into these aligned holes 62n4, 67g, the other protruded portion 62n1 is secured to and supported by the blade supporting portion 67. With this arrangement, unlike to the conventional cases, since only one side of the blade is secured by the screw, it is possible to reduce the number of parts and to improve the assembling operability.

In the aforementioned embodiments, while an example that the cleaning means having the blade 13a attached thereto or the developing means having the blade 12e attached thereto is integrally incorporated into the cartridge together with the photosensitive drum was explained, the blade attaching techniques shown in the above-mentioned embodiments can be applied to an image forming apparatus wherein a photosensitive drum, cleaning device or developing device is attached to a frame of the apparatus.

In the above-mentioned embodiments, while an example that both of the developing blade 12e and the cleaning blade 13a are attached in the same manner was explained, even when either the blade 12e or the blade 13a is attached in the manner shown in one of the above-mentioned embodiments, the assembling ability is improved in comparison with the conventional cases.

Next, the cleaning blade 13a and the blade support member 13a1 will be further fully described with reference to Figs. 82 to 88.

Fig. 82 is a partial plan view of the integrally formed blade support member 13a1 and cleaning blade 13a, and Fig. 83 is a side view thereof. As mentioned above, the cleaning blade 13a is made of polyurethane rubber having the hardness of 60° - 73° and preferably 62° - 68° (JIS A-hardness). Further, the blade support member 13a1 is formed from a cold rolled steel plate (SECC) having a flatness of 0.08 or less and a thickness of 1.0 mm - 1.6 mm (preferably,

1.2 mm in consideration of the strength and the bending accuracy).

Incidentally, the support member 13a1 has a bending angle  $\beta$  which has a relation  $90^\circ \leq \beta < 165^\circ$  (Fig. 83). The blade 13a and the support member 13a1 are integrally interconnected via an adhesive 13a6. In this case, an edge portion 13a5 of the polyurethane rubber 13a is cut off by a cutter (not shown) to obtain the smoothness. Further, as mentioned above, the support member 13a1 according to this embodiment has a projection 43b as a protruded portion protruding longitudinally from a supporting portion 13a7 for supporting the polyurethane rubber blade 13a, and a lower end 43b2 of the projection is substantially parallel with the edge portion 13a5 of the blade 13a.

When the support member 13a1 is attached to a frame 15a, the edge portion 13a5 of the blade 13a is correctly positioned by abutting the lower end 43b2 against a lower end 44b2 of the frame 15a, so that the edge portion 13a5 can be uniformly abutted against the peripheral surface of the photosensitive drum 9. Further, a threaded hole 45 as an attaching hole is formed in the blade support member 13a1. The support member 13a1 is secured to the frame 15a by a screw 59 threaded into the threaded hole 45. Incidentally, the support member may be secured to the frame 15a by inserting a projection (same material as the frame 15a) formed on the frame into the hole 45 and then by heat-caulking the projection.

In this embodiment, the attaching hole 45 is formed in the protruded portion 43. That is to say, a center of the hole 45 is positioned at a location spaced apart longitudinally outwardly from a side edge Q of the supporting portion 13a7 of the support member 13a1 by a distance P, and a radius r of the attaching hole 45 is set to be smaller than the distance P ( $r < P$ ).

More particularly, as an example, a diameter of the hole 45 was about 3.2 mm ( $r = \text{about } 1.6 \text{ mm}$ ) (Incidentally, in this embodiment, a most preferable example was shown when the blade support member is secured by the screw 59 (Fig. 73) having a diameter of 2.6 mm, but the diameter of the hole may be 2.7 mm - 3.6 mm), the distance P was about 3.8 mm, the thickness of the steel plate was about 1.2 mm, and the blade 13a was formed from polyurethane rubber having a thickness of about 1.7 mm and a hardness of  $65^\circ \pm 3^\circ$ . Further, the following dimensions were used: (i) S = about 13.0 mm, (ii) T = about 9.7 mm, (iii) U = about 10.2 mm, (iv) R1 = about 2.2 mm, (v) R2 = about 4.8 mm, (vi) R3 = about 2.0 mm, and (vii) R4 = about 4.5 mm.

Where, S is a distance between the lower end 43b2 of the blade support member 13a1 and the edge portion 13a5 of the blade 13a, and T is a distance between the lower end 43b2 and a bent portion i.

In this way, by arranging the whole area of the

hole 45 in the protruded portion 43b, in other words, by particularly providing areas R1, R2, R3 around the hole 45, the following advantages can be obtained:

(i) By providing the area R1, when the hole 45 is secured by the screw of heat-caulking, although the steel plate is distorted more or less by the tightening torque or heat, such distortion does not influence upon the edge portion 13a5 of the blade, thereby maintaining the adequate cleaning ability; and

(ii) By providing the areas R2, R3, when the hole 45 is formed, although the steel plate is distorted more or less, such distortion does not influence upon the lower end 43b2 and the side end 43b3 which are used to position the attaching position, and thus, since the support member 13a1 can be correctly attached to the frame 15a at a predetermined position, it is possible to maintain the adequate cleaning ability.

Incidentally, in the above description, while an example that a round or cylindrical hole is used as the attaching hole was explained, it is preferable that the same relationship should be satisfied even when an elongated slot hole is used (refer to Figs. 63 to 70 and 74). Thus, as in the case of the support member according to this embodiment, when a round hole is formed in one end portion and an elongated hole is formed in the other end portion, if the round hole formed in one end portion satisfies the above relationship, the same advantage as mentioned above will be obtained. Incidentally, in this embodiment, a longitudinal dimension of the elongated hole is about 4.5 mm, and a widthwise dimension of the elongated hole is about 3.2 mm.

Furthermore, in this embodiment, the elongated hole is arranged to satisfy the relationship same as that of the round hole, and the whole area of the elongated hole is disposed in the protruded portion which has a length of about 9 mm - 10 mm.

Further, regarding the above-mentioned arrangement, a plurality of samples wherein the protruded portions 43b have various lengths within a range of 4 mm - 22 mm were manufactured, and the attaching accuracy of the portion S was measured when each sample was attached to the frame 15a. The result was shown in Fig. 84. An area below the dot and chain line shown in Fig. 84 is a region within which the attaching accuracy that does not cause any problem in the practical use can be obtained. Thus, it was found that, when the length (U) of the protruded portion 43b was in a range of 5 mm - 20 mm, the adequate attaching accuracy could be obtained.

It seems that, if the length (U) of the protruded portion 43b is smaller than 5 mm, a length of the lower end 43b2 as the positioning reference will become too small, with the result that the positioning accuracy regarding the frame 15a cannot be obtained sufficiently when the blade support member is attached to

the frame 15, and that, if the length (U) of the protruded portion 43b is greater than 20 mm, the length of the lower end 43b2 will become too great, with the result that the straightness of the lower end 43b2 cannot be obtained sufficiently when the blade support member 13a1 is manufactured.

Now, the relation regarding the thickness and angle between the support member 13a1 and the blade 13a will be explained with reference to Figs. 83 to 88.

First of all, sizes of various portions of the integrally formed support member 13a1 and blade 13a will be explained with reference to Fig. 83. Incidentally, Fig. 83 is a schematic side view, wherein the support member 13a1 and the blade 13a are illustrated in an enlarged scale with respect to the photosensitive drum 9 for clarify's sake:

- (i) Bending angle ( $\beta$ ) of support member 13a1 about 115 degrees;
- (ii) Length (h1) of vertical portion h of support member 13a1 about 15.5 mm;
- (iii) Length (i1) of bent portion i of support member 13a1 about 7.5 mm;
- (iv) Thickness (t) of support member 13a1 about 1.2 mm;
- (v) Imaginary entry amount (b) of blade 13a with respect to photosensitive drum 9 about 0.7 - 1.3 mm;
- (vi) Width (c1) of tip end surface c of blade 13a (thickness of tip end of blade) about 1.7 mm;
- (vii) Length (d1) of vertical surface d of blade 13a about 1.5 mm;
- (viii) Length (k1) of inclined surface k of blade 13a about 5.0 mm;
- (ix) Length (v1) of root flat surface v of blade 13a about 2.0 mm;
- (x) Length (m1) of flat surface (abutment surface) m of blade 13a about 9.5 mm;
- (xi) Length (j1) of free end from tip end surface c of blade 13a to tip end of support member 13a1 about 7.5 mm;
- (xii) Thickness (e) of root of blade 13a about 2.6 mm;
- (xiii) Thickness (f) at one side of engagement portion of blade 13a against support member 13a1 about 0.8 mm;
- (xiv) Thickness (g) at the other side of engagement portion of blade 13a against support member 13a1 about 0.6 mm;
- (xv) Set abutment angle ( $\alpha$ ) of blade 13a against photosensitive drum 9 (angle between flat surface m of blade 13a and tangential line on photosensitive drum at point where blade 13a is contacted with photosensitive drum) about 23 - 25 degrees;
- (xvi) Angle ( $\theta$ ) between flat surface (abutment surface) m and a straight line  $\ell 1$  connecting between edge portion 13a5 of blade 13a abutted

against photosensitive drum 9 and rear end i2 of bent portion i of support member 13a1 about 18 degrees;

(xvii) Length of blade 13a in longitudinal direction about 240 mm.

First of all, the angle  $\theta$  between the flat surface m and the straight line  $\ell 1$  (dot and chain line in Fig. 83) connecting between the edge portion 13a5 (apex between the front end surface c and the flat surface m of the elastic blade 13a) and the rear end i2 of the bent portion i of the support member 13a1, according to the illustrated embodiment, will be explained. As mentioned above, in this embodiment, the angle  $\theta$  was selected to about 18 degrees.

This angle  $\theta$  will be explained. First of all, in order to perform the cleaning of the toner having small particles effectively, it is considered that the abutment pressure of the blade 13a against the photosensitive drum 9 may be increased. It means that the imaginary entry amount b (Fig. 83) of the edge portion 13a5 of the blade 13a regarding the photosensitive drum 9 is increased. When the abutment pressure is increased, the friction force F between the surface of the blade 13a and the surface of the photosensitive drum 9 is also increased. Thus, the blade 13a performing the cleaning of the toner while repeating the minute "stick-slip" in response to the rotation of the drum 9 increases the vibration of the tip end of blade due to the stick-slip, with the result that the support member 13a1 itself is vibrated.

Accordingly, in the conventional case, the vibration of the tip end of the blade was enhanced by the vibration of the support member 13a1, thereby generating the undesirable noise (for example, at the angle  $\theta$  less than 16 degrees, the undesirable noise occurred frequently). Incidentally, in this case, the angle  $\beta$  generally becomes 90° plus set abutment angle  $\gamma$  of the blade 13a (i.e.,  $\gamma > 90^\circ$ ).

Therefore, in order to solve the above problem, the inventors paid attention to a relation between the abutment pressure of the blade 13a and the strength of the steel plate. First of all, the length of the free end j of the blade 13a is set to have a value of about 6 mm - 9 mm in consideration of a relation between the abutment pressure and a space in which the cleaning device is installed. Now, in this condition, the inventors paid attention to the angle  $\theta$  and test was effected. As a result, it was found that, when the angle  $\theta$  was set greater than 18°, even if the abutment pressure was set to the required value, the support member 13a1 itself was not vibrated, thus preventing the undesirable noise. This will be further explained hereinafter.

When it is assumed that the length j1 of the free end j of the blade 13a is substantially constant, the strength of the support member 13a1 (steel plate) is determined by a ratio between the length h1 of the vertical portion h and the length i1 of the bent portion

i. Thus, in the illustrated embodiment, in consideration of the slight variation of the length  $jl$  of the free end, such relation is defined by the angle  $\theta$  between the flat surface (abutment surface)  $m$  of the blade 13a and the straight line connecting between the edge portion 13a5 of the blade and the rear end  $i2$  of the bent portion of the support member 13a1.

Now, in order to set the angle  $\theta$  greater than  $18^\circ$ , it is considered that the angle  $\beta$  is decreased, or the bent portion  $i$  is lengthened and at the same time the vertical portion  $h$  is shortened. In any cases, it is possible to increase the strength of the support member 13a1 itself. Accordingly, in the illustrated embodiment, even if the stick-slip at the tip end of the blade is increased by increasing the abutment pressure of the blade, since the strength of the support member 13a1 was increased, it is possible to positively suppress the vibration. Thus, the vibration of the support member 13a1 does not occur and the undesirable noise is prevented. Now, it is not necessary that the angle  $\theta$  is preferable as it becomes greater. That is, the greater the angle  $\theta$  (for example, the longer the bent portion  $i$ ) the greater the size of the cleaning blade as a single part, and, thus, the greater the cleaning device itself. To avoid this, in the illustrated embodiment, an upper limit of the angle  $\theta$  is set or defined to achieve the compactness of the cleaning blade as the single part, and, thus, the cleaning device itself.

Considering the strength of the support member 13a1, it is preferable that the lengths of the vertical portion  $h$  and the bent portion  $i$  satisfy the following relation:

$$f > n \cdot g \quad (n \geq 0.38).$$

By satisfying this relation, the satisfied strength causing less vibration can be obtained. In this case, preferably, by selecting the value  $n$  to have a relation  $n < 1$ , the cleaning device is prevented to become more large-sized than it needs. Further, so long as the above relation  $f > n \cdot g$  is satisfied, the thickness  $f$  can be reduced as the thickness  $g$  is decreased. Accordingly, both of the thickness  $f$  and the thickness  $g$  of the support member 13a1 can be reduced. Therefore, the flatness can be further improved. Thus, the blade 13a can be set with high accuracy and the compactness of the cleaning device can be achieved.

Explaining in detail, it is preferable that the vertical portion  $h$  of the support member 13a1 and the free end  $j$  of the blade 13a satisfy the following relation:

$$2 \leq h \leq 2.2 j.$$

Now, the reason why the vertical portion  $h$  is regulated more than 2 is the fact that the adhesion width 13a6 of at least 2 mm is required between the support member 13a1 and the blade 13a (in consideration of the peeling strength) regardless of the length of the free end  $j$ , and the reason why the vertical portion  $h$  is regulated less than 2.2  $j$  is the fact

that, if the value  $h$  is more than 2.2  $j$ , the flatness will be worsened extremely.

When the above conditions or relations are satisfied, the cleaning blade 13a and the support member 13a1 which are small-sized and light-weighted can be obtained. Further, even when the abutment pressure between the blade 13a and the photosensitive drum 9 is increased, the undesirable noise can be prevented, and the good cleaning can be achieved even in case of the toner having small diameter particles.

The test result will be described hereinbelow. The length  $jl$  of the free end was set to 7.5 mm, the length  $hl$  of the vertical portion was set to 15.5 mm, the length  $i1$  of the bent portion was set to 7.5 mm, the bending angle  $\beta$  was set to 115 degrees and the angle  $\theta$  was set to 18 degrees to satisfy the above-mentioned relations. In this condition, the cleaning blade comprising the integrally formed blade 13a and support member 13a1 was abutted against the photosensitive drum 9 with an abutment pressure greater than the normal abutment pressure, and the endurance test (wherein 4000 copies were to be obtained) was effected by using the above-mentioned apparatus with toner having small diameter particles under the normal environmental condition. As a result, it was found that there was no undesirable noise from the beginning to the end and the good cleaning ability was ascertained.

To the contrary, when the length  $i1$  of the bent portion  $i$  is set to 5.5 mm, the angle  $\theta$  becomes 15 degrees. By using a cleaning blade having such relation, the same test was effected. As a result, it was found that the undesirable noise was continued to occur from the beginning to several hundred copies.

Normally, the lubricant such as carbon fluoride was applied to the tip end of the blade. Nevertheless, the undesirable noise was generated. However, after several hundred copies, the undesirable noise was disappeared. This means that a large amount of toner is accumulated on the blade edge portion 13a5, thereby increasing the lubricating ability.

Further, in order to increase the strength of the support member 13a1, it is also considered that the thickness of the support member 13a1 itself is increased. However, if the thickness of the support member 13a1 is increased to 15 mm, for example, the flatness of the support member will be worsened during the manufacture of the support member.

Incidentally, in the above description, while an example that, in case of the toner having the small diameter particles, the undesirable noise is generated when the abutment pressure is increased to increase the friction force  $F$  was explained, the present invention is not limited to use the toner having the small diameter particles. For example, the friction force  $F$  greatly depends upon the coefficient of friction between the photosensitive drum and the abutment

surface of the blade, and the matching of materials. Accordingly, it is feared that, in the cleaning of the toner having normal diameter particles, the undesirable noise is generated even when the normal abutment pressure (low abutment pressure) is used. Also in this case, by satisfying the aforementioned conditions according to the present invention, it is possible to prevent the undesirable noise.

As mentioned above, by selecting the angle  $\theta$  (between the abutment surface of the blade, and the straight line connecting between the rear end of the belt portion of the support member and the edge portion of the blade contacting with the photosensitive drum) to  $18^\circ - 22^\circ$ , it is possible to increase the strength of the support member without making the support member large-sized, and to prevent the undesirable noise.

Next, the thickness of the blade 13a will be explained with reference to Figs. 83 and 85 to 88.

In this embodiment, the thickness of the blade 13a at various locations satisfies the following relations:

$$c1 < e \leq 2c1, f > g, \text{ and } c1 > d1.$$

Where,

- c1: Width of the end surface c of the blade 13a (thickness of the tip end of the blade 13a);
- e: Thickness of the root of the blade 13a;
- d1: Length of the vertical portion d of the blade 13a;
- f: Thickness of the engagement portion (at the side of the flat surface m) of the blade 13a against the support member 13a1; and
- g: Thickness of the engagement portion (at the side of the inclined surface k) of the blade 13a against the support member 13a1.

Incidentally, the conventional integrally formed support member and blade generally had the following relations:

$$c1 < d1, g > f, \text{ and } 2c1 < e.$$

The above relations according to this embodiment will be explained in order. First of all, by satisfying the relation  $c1 < e$ , the concentration of stress at a portion of the blade 13a is prevented, and the permanent deformation is suppressed to the utmost. Further, by satisfying the relations  $e \leq 2c1$  and  $f > g$ , the hardened contraction of rubber is suppressed to the utmost, thereby maintaining the parallelism of the edge portion 13a5 in the longitudinal direction accurately to the utmost. In this way, the parallelism of the edge portion can be improved. Further, even if only the parallelism is improved, the cleaning of the toner having the small diameter particles will be insufficient, so that the toner having particles smaller than the average particle diameter cannot sometimes be cleaned. Thus, in this embodiment, in order to improve the cleaning ability, regarding the abutment pressure of the blade 13a against the photosensitive drum 9, the relation  $c1 > d1$  is satisfied as mentioned

above. In this way, the rigidity of the blade 13a is improved and increased. That is to say, the tip end of the blade 13a is prevented from shifting in the rotation direction of the photosensitive drum 9, thus preventing the so-called "turn-up" of the blade. This seems that the rigidity of the blade 13a in the longitudinal direction can be increased by designing the end portion of the blade to have the relation  $c1 > d1$ .

Now, the so-called "turn-up" phenomenon of the blade will be explained with reference to Fig. 85.

As shown in Fig. 85, the blade 13a is subjected to a normal (vertical) drag N from the photosensitive drum 9, a friction force F between the drum 9 and the blade 13a, and a resultant drag force R resulting from the drag N and the friction force F. Thus, when the abutment pressure is increased, the normal drag N is increased and the friction force F is more increased, with the result that the tip end of the blade 13a is shifted in the rotation direction of the drum 9, thus causing the so-called "turn-up" phenomenon. However, in this embodiment, as mentioned above, since the rigidity of the blade 13a is increased, the "turn-up" phenomenon can be prevented.

Further, in this embodiment, with the arrangement as mentioned above, the permanent deformation amount can be reduced. This will be explained hereinafter.

A table shown in Fig. 86 indicates the relationship between the entry amount b of the blade and the permanent deformation amount, regarding the above-mentioned conventional blade and the blade according to the aforementioned embodiment of the present invention. That is to say, the table shows the result of test wherein, after the blades 13a were abutted against the photosensitive drum 9 with the entry amounts of 0.8 mm and 1.1 mm, respectively, for 5 hours at a temperature of  $45^\circ\text{C}$  (for promotion), the permanent deformation amounts of the blades 13a were measured. As apparent from the table, in the conventional blade, the percentage of the permanent deformation was about 10 %. To the contrary, in the blade according to the above-mentioned embodiment of the present invention, the percentage of the permanent deformation was reduced to about 5 %. The reason seems that, according to this embodiment of the present invention, the rigidity of the end portion of the blade is increased (due to  $c1 > d1$ ) and the elasticity of the blade at the side of the flat surface (abutment surface) m abutted against the support member 13a1 is increased (due to  $f > g$ ).

Incidentally, in the blade configuration, the length d1 of the vertical surface d must be at least 1 mm, because, after the blade is molded with rubber, the end portion of the blade should be cut to form the edge portion 13a5 with high accuracy. That is to say, when the blade is cut, since a cutter is moved from the side of the abutment surface of the blade in the longitudinal direction while holding the vertical portion d,



the vertical portion of at least 1 mm must be maintained as the holded portion. If the cutting portion cannot be held directly, it is feared that the edge portion 13a5 cannot be cut with high accuracy.

Further, when it is desired to further reduce the permanent deformation amount, the thickness of the whole blade may be increased in accordance with the above-mentioned relations. Since the percentage of the permanent deformation is determined by the configuration of the blade, if the entry amount  $b$  is small, when the abutment pressure is increased, the permanent deformation amount can be further reduced.

Next, the abut angle in accordance with the above-mentioned embodiment will be explained.

Now, as a factor required to stably maintain the high cleaning ability, there is the abut angle at the tip end of the blade, as well as the aforementioned factors. As shown in Fig. 87, the abut angle is defined as an angle  $\beta$  between a tangential line at a contacting point between the edge portion 13a5 of the blade and the surface of the photosensitive drum 9, and a straight line connecting between a point  $y$  spaced apart from the contacting point 13a5 by 0.5 mm along the blade abutment surface  $m$  and the contacting point 13a5. That is to say, the abut angle is an angle of the blade abutting against the photosensitive drum 9. Incidentally, the abut angle was determined by actually abutting the blade 13a against the photosensitive drum 9 with a certain entry amount and by visually measuring an abut angle with the aid of a microscope.

Now, regarding the above-mentioned conventional blade configuration and the above-mentioned blade configuration according to the present invention, a relation between the abut angle of the edge portion of the blade and the blade entry amount  $b$  is shown in Fig. 88. According to the inventors investigation, it was found that a range of the abut angle  $\beta$  for stably maintaining the cleaning ability was  $6^\circ \leq \beta \leq 16^\circ$ . Further, in consideration of various vibrations, the eccentricity of the photosensitive drum 9 and the like, the range of the abut angle is preferably  $8^\circ \leq \beta \leq 14^\circ$ . In consideration of the above, comparing the conventional blade configuration with the blade configuration according to this embodiment of the present invention, it is apparent that the abut acceptable range of the blade according to this embodiment is wider than that of the conventional blade in reference to the entry amount  $b$ . For example, as shown in Fig. 88, in order to keep the abut angle of the blade tip end within the range of  $6 - 16^\circ$ , it is apparent that, in the conventional blade, the blade entry amount must be  $0.5 - 1.03$  mm ( $0.53$  mm in range). To the contrary, in the blade according to this embodiment, the entry amount may be  $0.6 - 1.26$  mm ( $0.66$  mm in range). Thus, setting range for the entry amount can be widened. Accordingly, even when the range for the entry amount  $b$  is set wider, the assembling ability can be

improved and the total cost can be reduced. Further, when the range for the entry amount  $b$  is set narrower as in the conventional case, the range of the abut angle of the blade end tip can be made narrower, thus maintaining the good cleaning ability stably for a long time and improving the reliability.

Incidentally, after the blade shown in Figs. 82 and 83 was incorporated into the above-mentioned process cartridge B and 4000 copies were obtained by the image forming apparatus A using such process cartridge under the normal environmental condition, it was found that the good cleaning ability could be maintained without damaging the photosensitive drum.

Further, in the aforementioned embodiments, in case of the toner having the small diameter particles, while an example that the friction force is increased by increasing the abut angle of the blade was explained, the present invention is not limited to the toner having the small diameter particles, but may be applied to any cases so long as the above-mentioned relations or conditions are satisfied regardless of the particle diameter of the toner, because it is apparent that the advantages of the present invention as mentioned above can be achieved so long as the above relations are satisfied.

As mentioned above, according to the cleaning blades and the blade support members in accordance with the aforementioned embodiments, it is possible to provide a blade member which can be made small-sized, can improve the positioning accuracy when it is attached to the process cartridge or to the cleaning device, can reduce the permanent deformation amount after attachment, can prevent the turn-up, can prevent the undesirable noise and can maintain the good performance for a long time.

## Claims

1. A method for attaching a blade support member supporting an elastic blade to opposed frames, comprising the steps of:  
 applying to said frames a force in a direction that said opposed frames are deflected to widen a distance between said opposed frames, before said blade support member is locked-to locking portions provided on said frames;  
 locking said blade support member to said locking portions; and  
 applying to said frames a force in a direction that the distance between said opposed frames is decreased, thereby securing said blade support member to said frames.
2. A method according to claim 1, wherein rigidity of said frames is smaller than rigidity of said elastic blade or said blade support member.

3. A method according to claim 1, wherein said elastic blade is a cleaning blade made of urethane rubber, and said cleaning blade scrapes residual toner from an electrophotographic photosensitive member in a condition that said blade support member formed from a metal plate is attached between said frames made of plastic material. 5
4. A method according to claim 1, wherein said elastic blade is a developing blade made of urethane rubber, and said developing blade regulates a thickness of a toner layer around a developing sleeve in a condition that said blade support member formed from a metal plate is attached between said frames made of plastic material. 10 15
5. A method according to claim 1, wherein said blade support member is secured to said frames by screws in a condition that both longitudinal ends of said blade support member are abutted against said frame while applying to said frames the force in the direction that the distance between said opposed frames is decreased. 20 25
6. A method according to claim 1, wherein said blade support member is secured to said frames in a condition that both longitudinal ends of said blade support member are abutted against surfaces substantially perpendicular to said frame while applying to said frames the force in the direction that the distance between said opposed frames is decreased. 30 35
7. A method according to claim 1, wherein the distance between said frames is widened by about 0.5 - 2 mm by applying to said frames a force of about 2 - 6 kgf in the direction that the distance between said opposed frame is widened. 40
8. A method according to claim 1, wherein the distance between said frames is decreased by about 0.1 - 1.5 mm by applying to said frames a force of about 1 - 4 kgf in the direction that the distance between said opposed frame is decreased. 45
9. A method according to claim 1, wherein said frames are made of polystyrene, acrylonitrile butadiene styrene, polyphenylene oxide or polyphenylene ether. 50
10. A method according to claim 1, wherein said locking portions provided on said frames including openings, and said blade support member is locked to said frames by press-fitting the ends of said blade support member into said openings. 55
11. A method according to claim 1, wherein a tool is used to apply to said frames the force in the direction that the distance between said opposed frame is widened. 5
12. A method according to claim 1, wherein a tool is used to apply to said frames the force in the direction that the distance between said opposed frame is decreased. 10
13. A method according to claim 1, wherein said frames are frames of a process cartridge which integrally incorporates therein an image bearing member and process means and which can removably be mounted within an image forming apparatus. 15
14. A method according to claim 1, wherein said frames are frames of a developing device. 20
15. A method according to claim 1, wherein said frames are frames of a cleaning device. 25
16. A process cartridge assembling method for attaching a cleaning blade to a process cartridge which can removably be mounted within an image forming apparatus, comprising the steps of:
  - applying to frames of said process cartridge a force in a direction that said opposed frames are deflected to widen a distance between said opposed frames, before a blade support member supporting said cleaning blade for removing toner from an image bearing member is locked to locking portions provided on said frames;
  - locking said blade support member to said locking portions; and
  - applying to said frames a force in a direction that the distance between said opposed frames is decreased, thereby securing said blade support member to said frames, thus assembling said process cartridge.
 30 35 40
17. A method according to claim 16, wherein said frames comprise a first frame and a second frame; said cleaning blade for scraping the toner from said image bearing member is attached to said first frame; and then said first frame is locked to said second frame including a charger roller for charging said image bearing member and a toner containing portion for containing toner used in a developing means, thereby assembling said process cartridge. 45 50
18. A method according to claim 16, wherein said process cartridge integrally incorporates therein at least a cleaning means, and an electrophotographic photosensitive member as a unit which 55

can be removably be mounted within said image forming apparatus.

19. A process cartridge assembling method for attaching a developing blade to a process cartridge which can removably be mounted within an image forming apparatus, comprising the steps of:

applying to frames of said process cartridge a force in a direction that said opposed frames are deflected to widen a distance between said opposed frames, before a blade support member supporting said developing blade for regulating a thickness of a toner layer around a developing sleeve is locked to locking portions provided on said frames;

locking said blade support member to said locking portions; and

applying to said frames a force in a direction that the distance between said opposed frames is decreased, thereby securing said blade support member to said frames, thus assembling said process cartridge.

20. A method according to claim 19, wherein said frames comprise a first frame and a second frame; said developing sleeve for developing a latent image formed on a photosensitive drum is attached to said first frame; and then said first frame is locked to said second frame including a charger roller for charging said photosensitive drum and a toner containing portion for containing toner used in a developing operation, thereby assembling said process cartridge.

21. A method according to claim 19, wherein said process cartridge integrally incorporates therein at least a developing means, and an electrophotographic photosensitive member as a unit which can be removably be mounted within said image forming apparatus.

22. An image forming apparatus to which a process cartridge can removably be mounted and which is adapted to form an image on a recording medium, comprising:

a mounting means capable of mounting a process cartridge assembled by applying to frames of said process cartridge a force in a direction that said opposed frames are deflected to widen a distance between said opposed frames, before a blade support member supporting a cleaning blade for removing toner from an image bearing member is locked to locking portions provided on said frames, by locking said blade support member to said locking portions, and by applying to said frames a force in a direction that the distance between said opposed

frames is decreased, thereby securing said blade support member to said frames; and

a convey means for conveying the recording medium.

23. An image forming apparatus to which a process cartridge can removably be mounted and which is adapted to form an image on a recording medium, comprising:

a mounting means capable of mounting a process cartridge assembled by applying to frames of said process cartridge a force in a direction that said opposed frames are deflected to widen a distance between said opposed frames, before a blade support member supporting a developing blade for regulating a thickness of a toner layer around a developing sleeve is locked to locking portions provided on said frames, by locking said blade support member to said locking portions, and by applying to said frames a force in a direction that the distance between said opposed frames is decreased, thereby securing said blade support member to said frames; and

a convey means for conveying the recording medium.

24. An image forming apparatus according to claim 22, wherein the image forming apparatus is an electrophotographic copying machine.

25. An image forming apparatus according to claim 23, wherein the image forming apparatus is an electrophotographic copying machine.

26. An image forming apparatus according to claim 22, wherein the image forming apparatus is a facsimile apparatus.

27. An image forming apparatus according to claim 23, wherein the image forming apparatus is a facsimile apparatus.

28. An image forming apparatus according to claim 22 wherein the image forming apparatus is a laser beam printer.

29. An image forming apparatus according to claim 23, wherein the image forming apparatus is a laser beam printer.

30. A process cartridge mountable to an image forming apparatus, comprising:

a frame;  
an image bearing member;  
a part attached by press-fit; and  
a member for screw-connecting said part.

31. A process cartridge according to claim 30, wherein said member for screw-connecting said part includes a threaded hole position in the proximity of a press-fitting area.
32. A process cartridge according to claim 30, wherein said part comprises a cleaning blade attached by the press-fit, for removing toner from said image bearing member.
33. A process cartridge according to claim 30, wherein said part comprises a developing blade attached by the press-fit, for regulating thickness of a toner layer on a surface of a toner carrying member for directing toner to a developing station.
34. A process cartridge according to claim 30, wherein said press-fit is effected by forcibly fitting a fitting projections formed on both longitudinal ends of a cleaning blade and/or a developing blade as said part into fitting portions formed on said frame.
35. An image forming apparatus for forming an image on a recording medium and adapted to mount a process cartridge therewithin, comprising:  
     mounting means capable of mounting a process cartridge including a frame, an image bearing member, a part attached by press-fit, and a member for screw-connecting said part; and  
     feeding means for feeding a recording medium.
36. A process cartridge according to claim 30 wherein said process cartridge integrally incorporates therein charger means, developing means or cleaning means as process means, and an electrophotographic photosensitive member as said image bearing member, as a unit which can be removably mounted within said image forming apparatus.
37. A process cartridge according to claim 30, wherein said process cartridge integrally incorporates therein at least one of charger means, developing means or cleaning means as process means, and an electrophotographic photosensitive member as said image bearing member, as a unit which can be removably mounted within said image forming apparatus.
38. A process cartridge according to claim 30, wherein said process cartridge integrally incorporates therein at least developing means as process means, and an electrophotographic

photosensitive member as said image bearing member, as a unit which can be removably mounted within said image forming apparatus.

39. An image forming apparatus according to claim 35, wherein said image forming apparatus is an electrophotographic copying machine.
40. An image forming apparatus according to claim 35, wherein said image forming apparatus is a laser beam printer.
41. An image forming apparatus according to claim 35, wherein said image forming apparatus is a facsimile.
42. A method for assembling a cleaning device for cleaning a surface to be cleaned, wherein:  
     an inclined surface and a projection are formed on an end face of an attachment surface of a cleaning member for cleaning said surface to be cleaned while contacting with said surface to be cleaned;  
     an inclined surface, a fitting portion and a recessed portion are formed on a frame to which said cleaning member is attached; and  
     said inclined surface of cleaning member is directed to said fitting portion along said inclined surface of said frame, thereby fitting said cleaning member into said fitting portion and fitting said projection of said cleaning member into said recessed portion of said frame.
43. An assembling method according to claim 42, wherein said cleaning member comprises an elastic cleaning blade, and a blade holder for supporting said cleaning blade, and said attachment surface is formed on said blade holder.
44. An assembling method according to claim 42, wherein said recessed portion of said frame is an opening formed in said frame.
45. An assembling method according to claim 42, wherein, when said inclined surface of said cleaning member is directed to said fitting portion, said frame is elastically widened outwardly and then said cleaning member is fitted into said fitting portion, and thereafter, said frame is returned to its original state.
46. An assembling method according to claim 42, wherein, after said cleaning member is fitted into said fitting portion and said projection of said cleaning member is fitted into said recessed portion of said frame, said blade holder is attached to said frame by a screw means if necessary.

47. An assembling method according to claim 42, wherein, after said cleaning member is fitted into said fitting portion and said projection of said cleaning member is fitted into said recessed portion of said frame, said blade holder is attached to said frame by screw means when re-cycled. 5
48. An assembling method according to claim 42, wherein said cleaning member comprises an elastic cleaning blade for removing the residual toner from said image bearing member. 10
49. An assembling method according to claim 42, wherein said cleaning member comprises a doctor blade for keeping a toner layer on a developing roller constant. 15
50. A process cartridge mountable to an image forming apparatus, comprising:  
a frame; and  
fitting portions formed on said frame and adapted to for sandwich and support a part; wherein an end of said part to be sandwiched and supported by said fitting portions of said frame is formed in an inclined configuration. 20 25
51. A process cartridge according to claim 50, wherein said part is a cleaning blade attached to said frame by press-fit, for removing toner from an image bearing member. 30
52. A process cartridge according to claim 50, wherein said part is a developing blade attached to said frame by press-fit, for keeping thickness of a toner layer constant on a developing sleeve for directing toner to a developing station. 35
53. A process cartridge according to claim 50, wherein said inclined configuration has a rounded contour in its cross-section. 40
54. A process cartridge according to claim 50, wherein a lubricant tape is stuck to said inclined configuration. 45
55. A process cartridge according to claim 52, wherein a lubricant is applied to said inclined configuration. 50
56. A blade member, comprising  
an elastic blade; and  
a support member for supporting said elastic blade and having a supporting portion for supporting said elastic blade, a protruded portion protruding from said supporting portion in a longitudinal direction thereof, and a whole formed in said protruded portion; wherein a length of said protruded portion 55
- in said longitudinal direction is more than 5 mm and less than 20 mm.
57. A blade member according to claim 56, wherein said elastic blade is made of polyurethane rubber.
58. A blade member according to claim 56, wherein said support member is formed from a cold rolled steel plate.
59. A blade member according to claim 56, wherein said protruded portion is provided on a longitudinal end of each of said supporting portions on both ends of said support member, and a single hole is formed in said supporting portion.
60. A blade member according to claim 56, wherein said elastic blade is adhered to said support member by adhesive.
61. A blade member according to claim 56, wherein, when said the blade member is attached to a member to which the blade member is attached, said protruded portion is locked on said member to which the blade member is attached.
62. A blade member according to claim 56, wherein said hole is a round hole.
63. A blade member according to claim 56, wherein said hole is an elongated slot hole.
64. A blade member according to claim 56, wherein said hole is a round hole or an elongated slot hole.
65. A blade member according to claim 56, wherein said hole formed in said protruded portion provided on a longitudinal end of said supporting portion on one end of said support member is a round hole, and said hole formed in said protruded portion provided on a longitudinal end of said supporting portion on the other end of said support member is an elongated slot hole.
66. A blade member according to claim 65, wherein said round hole has a diameter of about 3.2 mm.
67. A process cartridge mountable within an image forming apparatus, comprising:  
(a) a frame;  
(b) an image bearing member provided in said frame; and  
(c) a blade member comprising an elastic blade, and a support member for supporting said elastic blade and having a supporting portion for supporting said elastic blade, a

protruded portion protruding from said supporting portion in a longitudinal direction thereof, and a hole formed in said protruded portion;

wherein a length of said protruded portion in said longitudinal direction is more than 5 mm and less than 20 mm.

68. A process cartridge according to claim 67, further comprising a charger roller acting on an electrophotographic photosensitive member as said image bearing member.
69. A process cartridge according to claim 67, further comprising a developing device acting on an electrophotographic photosensitive member as said image bearing member.
70. An image forming apparatus to which a process cartridge can be removably mounted and adapted to form an image on a recording medium, comprising:  
(A) a mounting means capable of mounting a process cartridge including (a) a frame, (b) an image bearing member provided in said frame, and (c) a blade member comprising an elastic blade, and a support member for supporting said elastic blade and having a supporting portion for supporting said elastic blade, a protruded portion protruding from said supporting portion in a longitudinal direction thereof, and a hole formed in said protruded portion, wherein a length of said protruded portion in said longitudinal direction is more than 5 mm and less than 20 mm; and  
(B) a convey means for conveying the recording medium.
71. An image forming apparatus according to claim 70, wherein the image forming apparatus is an electrophotographic copying machine.
72. An image forming apparatus according to claim 70, wherein the image forming apparatus is a laser beam printer.
73. An image forming apparatus according to claim 70, wherein the image forming apparatus is a facsimile apparatus.
74. A method for attaching a blade member to a frame, which blade member comprises an elastic blade, and a support member for supporting said elastic blade and having a supporting portion for supporting said elastic blade, a protruded portion protruding from said supporting portion in a longitudinal direction thereof, and a hole formed in said protruded portion;

wherein a length of said protruded portion in said longitudinal direction is more than 5 mm and less than 20 mm is attached to said frame, said hole is locked on said frame.

75. A method according to claim 74, wherein said hole is locked on said frame by a screw.
76. A method according to claim 74, wherein said protruded portion is locked on said frame by press-fit.
77. A method according to claim 74, wherein said hole is locked on said frame by heat-caulking.
78. A blade member, comprising:  
an elastic blade; and  
a support member for supporting said elastic blade;  
wherein a thickness of a portion of said elastic blade which is engaged by said support member is greater than a thickness of a tip end of said elastic blade, and said thickness of said portion is greater than said thickness of said tip end by twice or less.
79. A blade member according to claim 78, wherein one side surface of said elastic blade in a longitudinal direction is flat, and the other side surface has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface.
80. A blade member according to claim 78, wherein a thickness of a portion of said elastic blade which is engaged by said support member at a side of said one side surface is greater than that of a portion of said elastic blade at a side of said the other side surface.
81. A blade member according to claim 78, wherein one side surface of said elastic blade in a longitudinal direction is flat, and the other side surface has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface, inclined with respect to said vertical surface; and a width of said end surface is greater than a length of said vertical surface.
82. A blade member according to claim 81, the length of said vertical surface is more than 1 mm.
83. A blade member according to claim 78, wherein said elastic blade is made of polyurethane rubber.

84. A blade member according to claim 78, wherein said support member is formed from a cold rolled steel plate.
85. A blade member according to claim 78, wherein said elastic blade is adhered to said support member by adhesive.
86. A process cartridge mountable within an image forming apparatus, comprising:  
 (a) a frame;  
 (b) an image bearing member provided in said frame; and  
 (c) a blade member comprising an elastic blade, and a support member for supporting said elastic blade;  
 wherein a thickness of a portion of said elastic blade which is engaged by said support member is greater than a thickness of a tip end of said elastic blade but smaller than twice thereof, and said elastic blade is abutted against said image bearing member to clean it.
87. A process cartridge according to claim 86, further comprising a charger roller acting on an electrophotographic photosensitive member as said image bearing member.
88. A process cartridge according to claim 86, further comprising a developing device acting on an electrophotographic photosensitive member as said image bearing member.
89. An image forming apparatus to which a process cartridge can be removably mounted and adapted to form an image on a recording medium, comprising:  
 (A) a mounting means capable of mounting a process cartridge including (a) a frame, (b) an image bearing member provided in said frame, and (c) a blade member comprising an elastic blade and a support member for supporting said elastic blade, wherein a thickness of a portion of said elastic blade which is engaged by said support member is greater than a thickness of a tip end of said elastic blade but smaller than twice thereof, and said elastic blade is abutted against said image bearing member to clean it; and  
 (B) a convey means for conveying the recording medium.
90. An image forming apparatus according to claim 89, wherein the image forming apparatus is an electrophotographic copying machine.
91. An image forming apparatus according to claim 89, wherein the image forming apparatus is a laser beam printer.
92. An image forming apparatus according to claim 89, wherein the image forming apparatus is a facsimile apparatus.
93. A method for attaching a blade member to a frame, which blade member comprises an elastic blade and a support member for supporting said elastic blade;  
 wherein a thickness of a portion of said elastic blade which is engaged by said support member is greater than a thickness of a tip end of said elastic blade but is smaller than twice thereof is attached to said frame, both end portions of said support member are locked on said frame.
94. A method according to claim 93, wherein said both end portions of said support member are locked on said frame by screws.
95. A method according to claim 93, wherein said both end portions of said support member are locked on said frame by press-fit.
96. A blade member, comprising:  
 an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface; and  
 a support member for supporting said elastic blade;  
 wherein a thickness of a portion of said elastic blade which is engaged by said support member at a side of said one side surface is greater than that of a portion of said elastic blade at a side of said the other side surface.
97. A blade member according to claim 96, wherein said elastic blade is made of polyurethane rubber.
98. A blade member according to claim 96, wherein said support member is formed from a cold rolled steel plate.
99. A blade member according to claim 96, wherein said elastic blade is adhered to said support member by adhesive.
100. A process cartridge mountable within an image forming apparatus, comprising:  
 (a) a frame;  
 (b) an image bearing member provided in said frame; and

- (c) a blade member comprising an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade, wherein a thickness of a portion of said elastic blade which is engaged by said support member at a side of said one side surface is greater than that of a portion of said elastic blade at a side of said the other side surface and said elastic blade is abutted against said image bearing member to clean it.
101. A process cartridge according to claim 100, further comprising a charger roller acting on an electrophotographic photosensitive member as said image bearing member.
102. A process cartridge according to claim 100, further comprising a developing device acting on an electrophotographic photosensitive member as said image bearing member.
103. An image forming apparatus to which a process cartridge can be removably mounted and adapted to form an image on a recording medium, comprising:
- (A) a mounting means capable of mounting a process cartridge including (a) a frame, (b) an image bearing member provided in said frame, and (c) a blade member comprising an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade, wherein a thickness of a portion of said elastic blade which is engaged by said support member at a side of said one side surface is greater than that of a portion of said elastic blade at a side of said the other side surface and said elastic blade is abutted against said image bearing member to clean it; and
- (B) a convey means for conveying the recording medium.
104. An image forming apparatus according to claim 103, wherein the image forming apparatus is an electrophotographic copying machine.
105. An image forming apparatus according to claim 103, wherein the image forming apparatus is a laser beam printer.
106. An image forming apparatus according to claim 103, wherein the image forming apparatus is a facsimile apparatus.
107. A method for attaching a blade member to a frame, which blade member comprises an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade, wherein a thickness of a portion of said elastic blade which is engaged by said support member at a side of said one side surface is greater than that of a portion of said elastic blade at a side of said the other side surface is attached to said frame, both end portions of said support member are locked on said frame.
108. A method according to claim 107, wherein said both end portions of said support member are locked on said frame by screws.
109. A method according to claim 107, wherein said both end portions of said support member are locked on said frame by press-fit.
110. A blade member, comprising:
- an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface; and
- a support member for supporting said elastic blade and having a bent portion at its rear end;
- wherein an angle between the flat surface of said elastic blade, and a straight line connecting the rear end of said support member to an apex between said end surface and said flat surface is more than 18 degrees and less than 22 degrees.
111. A blade member according to claim 110, wherein said elastic blade is made of polyurethane rubber.
112. A blade member according to claim 110, wherein said support member is formed from a cold rolled steel plate.
113. A blade member according to claim 110, wherein said elastic blade is adhered to said support member by adhesive.



114. A process cartridge mountable to an image forming apparatus, comprising:

(a) a frame;

(b) an image bearing member provided in said frame; and

(c) a blade member comprising an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade and having a bent portion at its rear end, wherein an angle between the flat surface of said elastic blade, and a straight line connecting the rear end of said support member to an apex between said end surface and said flat surface is more than 18 degrees and less than 22 degrees, said elastic blade being abutted against said image bearing member to clean it.

115. A process cartridge according to claim 114, further comprising a charger roller acting on an electrophotographic photosensitive member as said image bearing member.

116. A process cartridge according to claim 114, further comprising a developing device acting on an electrophotographic photosensitive member as said image bearing member.

117. An image forming apparatus to which a process cartridge can be removably mounted and adapted to form an image on a recording medium, comprising:

(A) a mounting means capable of mounting a process cartridge including (a) a frame, (b) an image bearing member provided in said frame, and (c) a blade member comprising an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade and having a bent portion at its rear end, wherein an angle between the flat surface of said elastic blade, and a straight line connecting the rear end of said support member to an apex between said end surface and said flat surface is more than 18 degrees and less than 22 degrees, said elastic blade being abutted against said image bearing member to clean it; and

(B) a convey means for conveying the recording medium.

118. An image forming apparatus according to claim 117, wherein the image forming apparatus is an electrophotographic copying machine.

119. An image forming apparatus according to claim 117, wherein the image forming apparatus is a laser beam printer.

120. An image forming apparatus according to claim 117, wherein the image forming apparatus is a facsimile apparatus.

121. A method for attaching a blade member to a frame, which blade member comprising an elastic blade one side surface of which is flat in a longitudinal direction is flat and the other side surface of which has a vertical portion perpendicular to an end surface of said elastic blade, and an inclined surface inclined with respect to said vertical surface, and a support member for supporting said elastic blade and having a bent portion at its rear end, wherein an angle between the flat surface of said elastic blade, and a straight line connecting the rear end of said support member to an apex between said end surface and said flat surface is more than 18 degrees and less than 22 degrees is attached to said frame, both end portions of said support member are locked on said frame.

122. A method according to claim 121, wherein said both end portions of said support member are locked on said frame by screws.

123. A method according to claim 121, wherein said both end portions of said support member are locked on said frame by press-fit.

FIG. 1

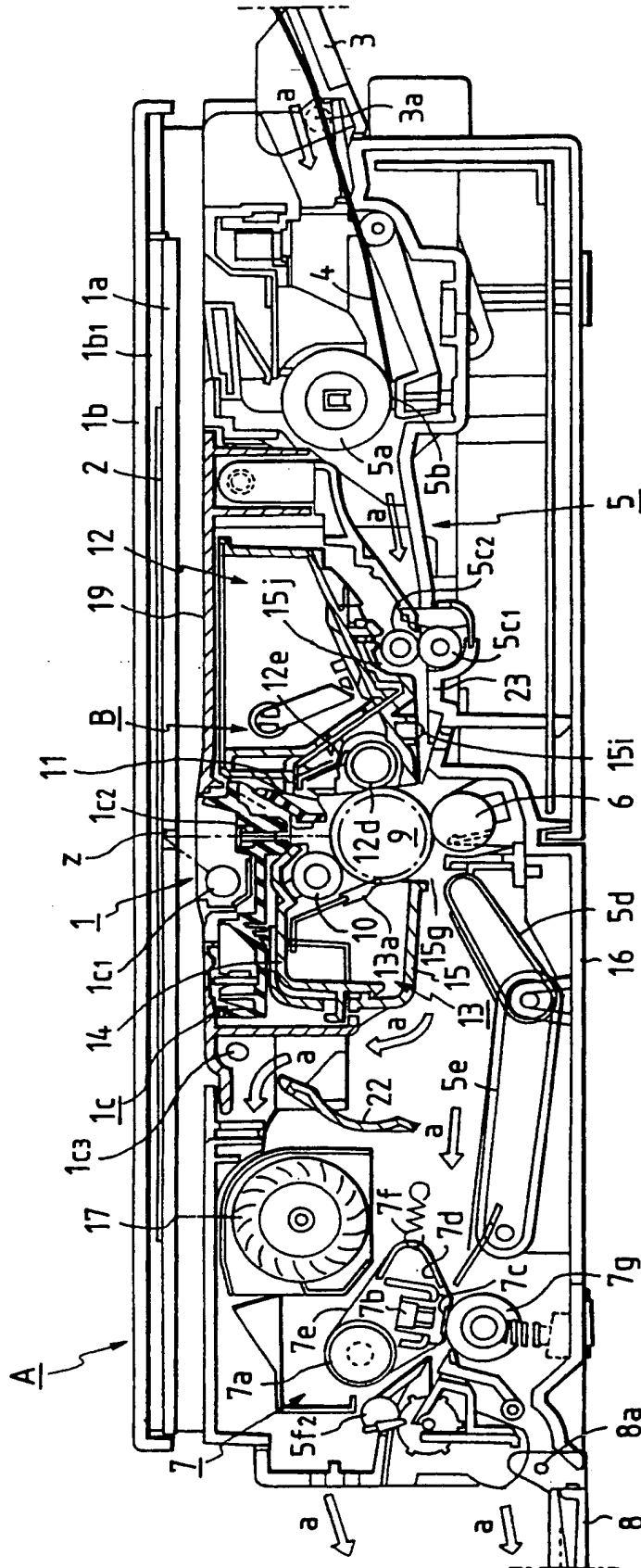


FIG. 2

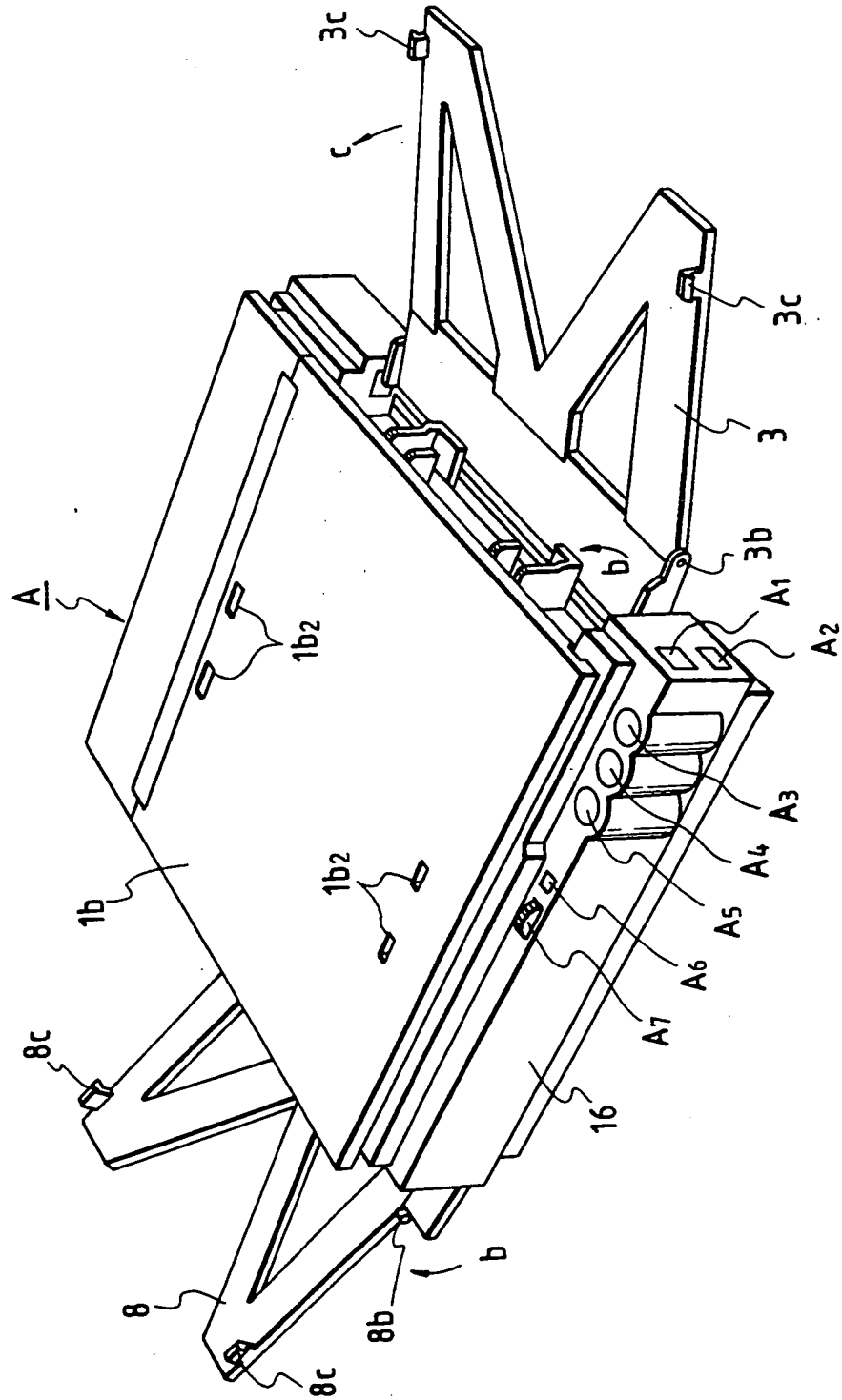


FIG. 3

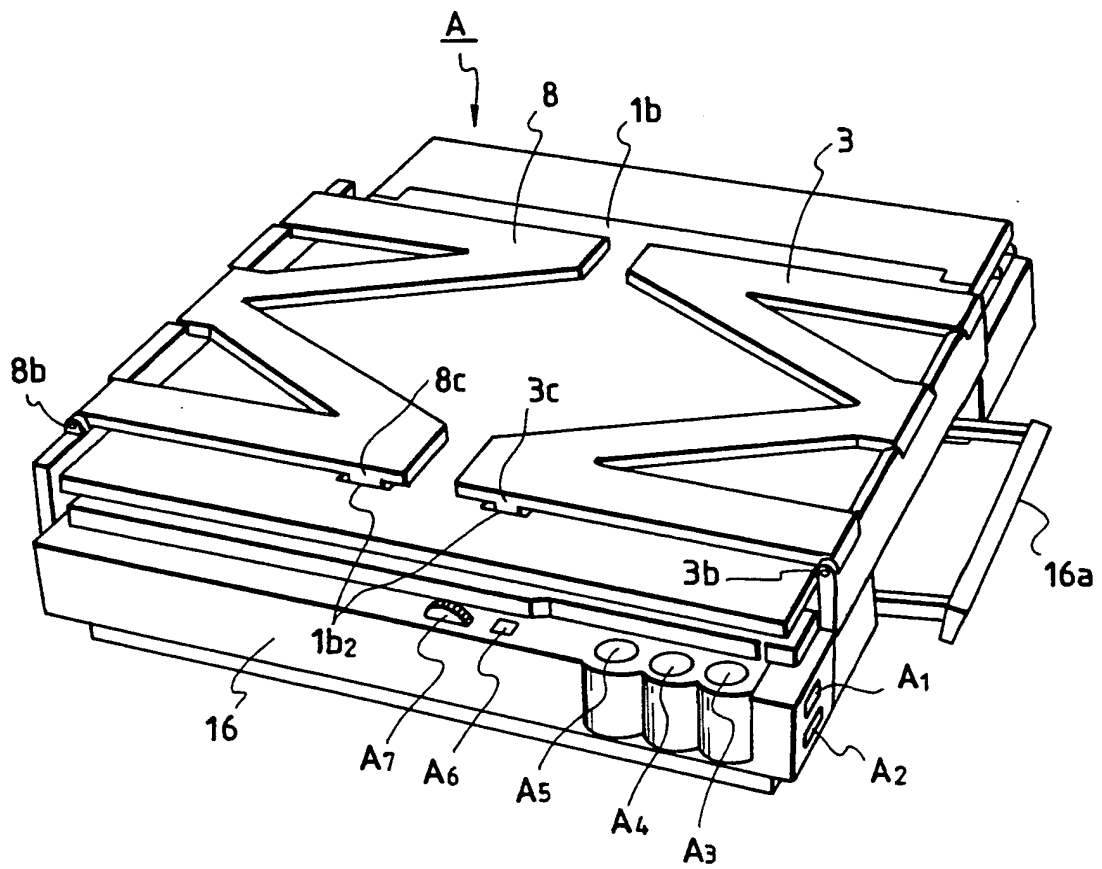


FIG. 4

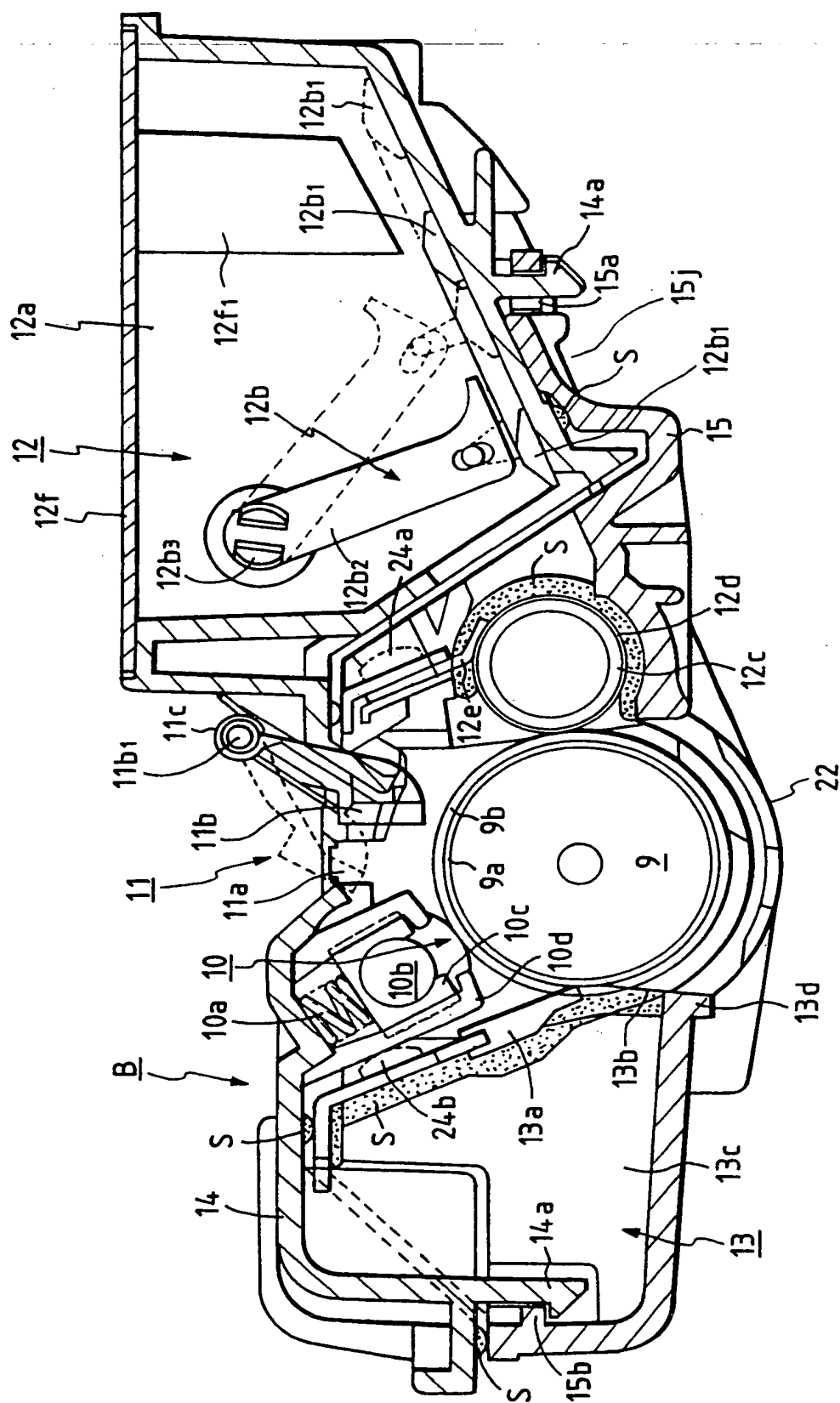


FIG. 5

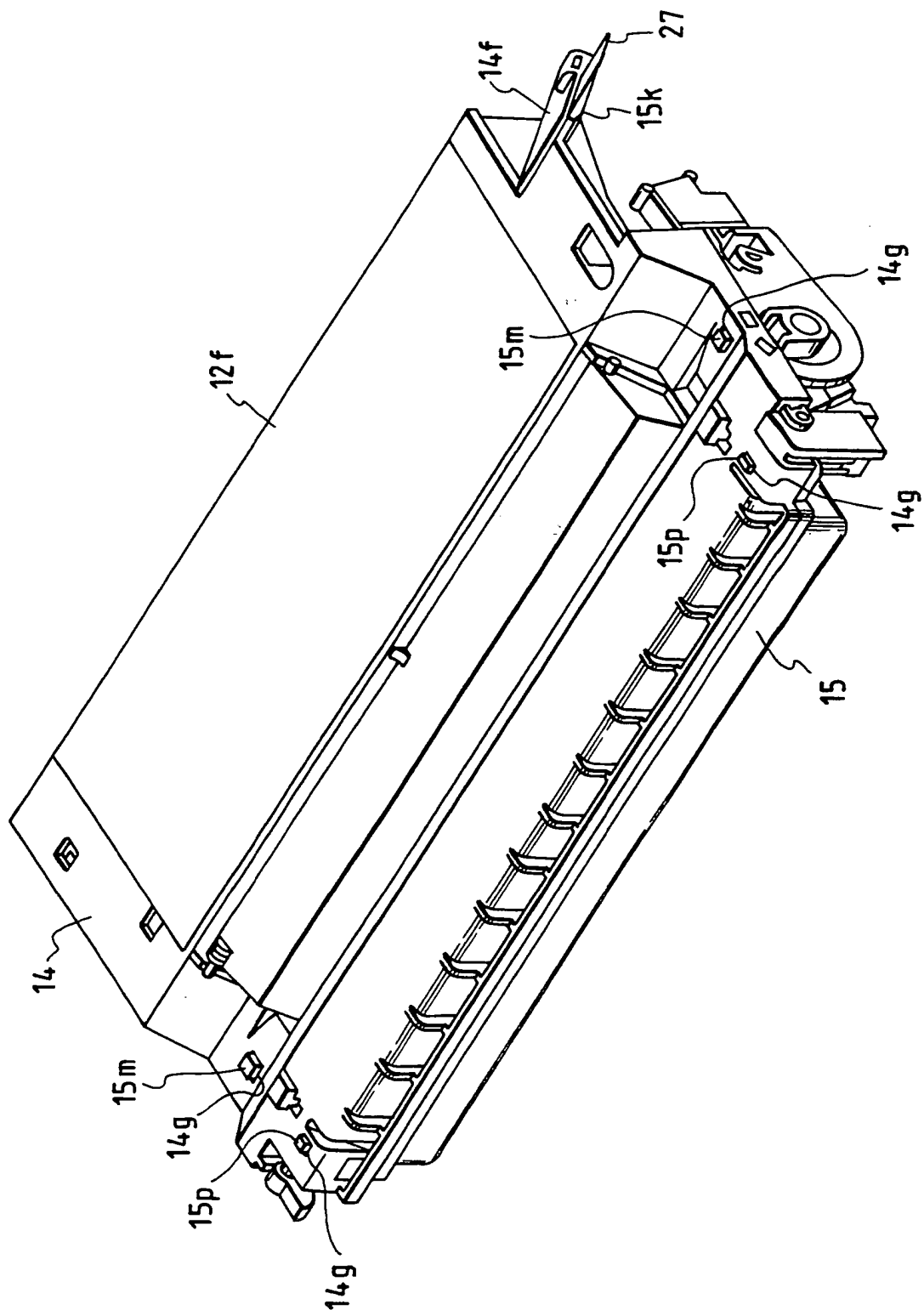


FIG. 6

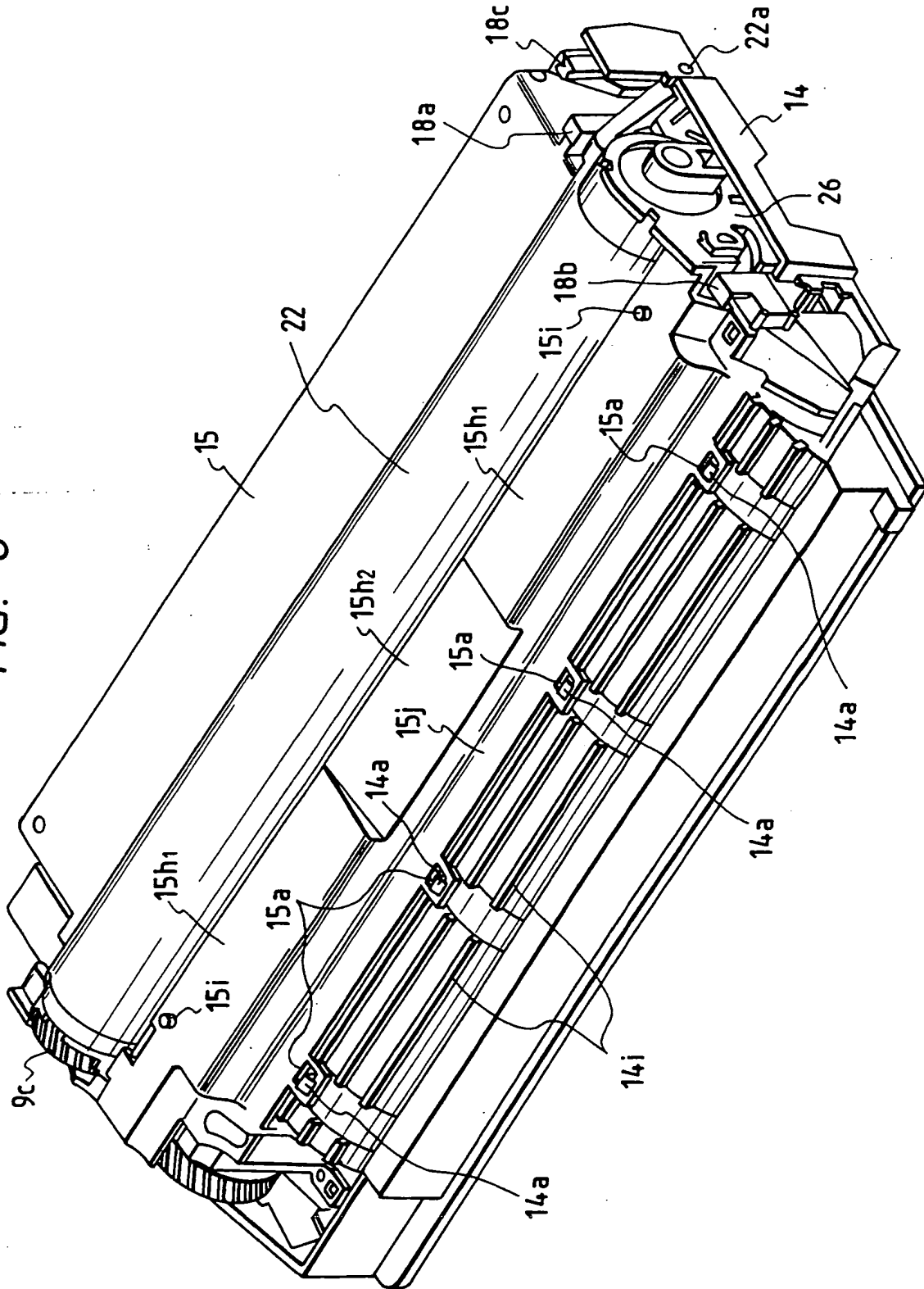


FIG. 7

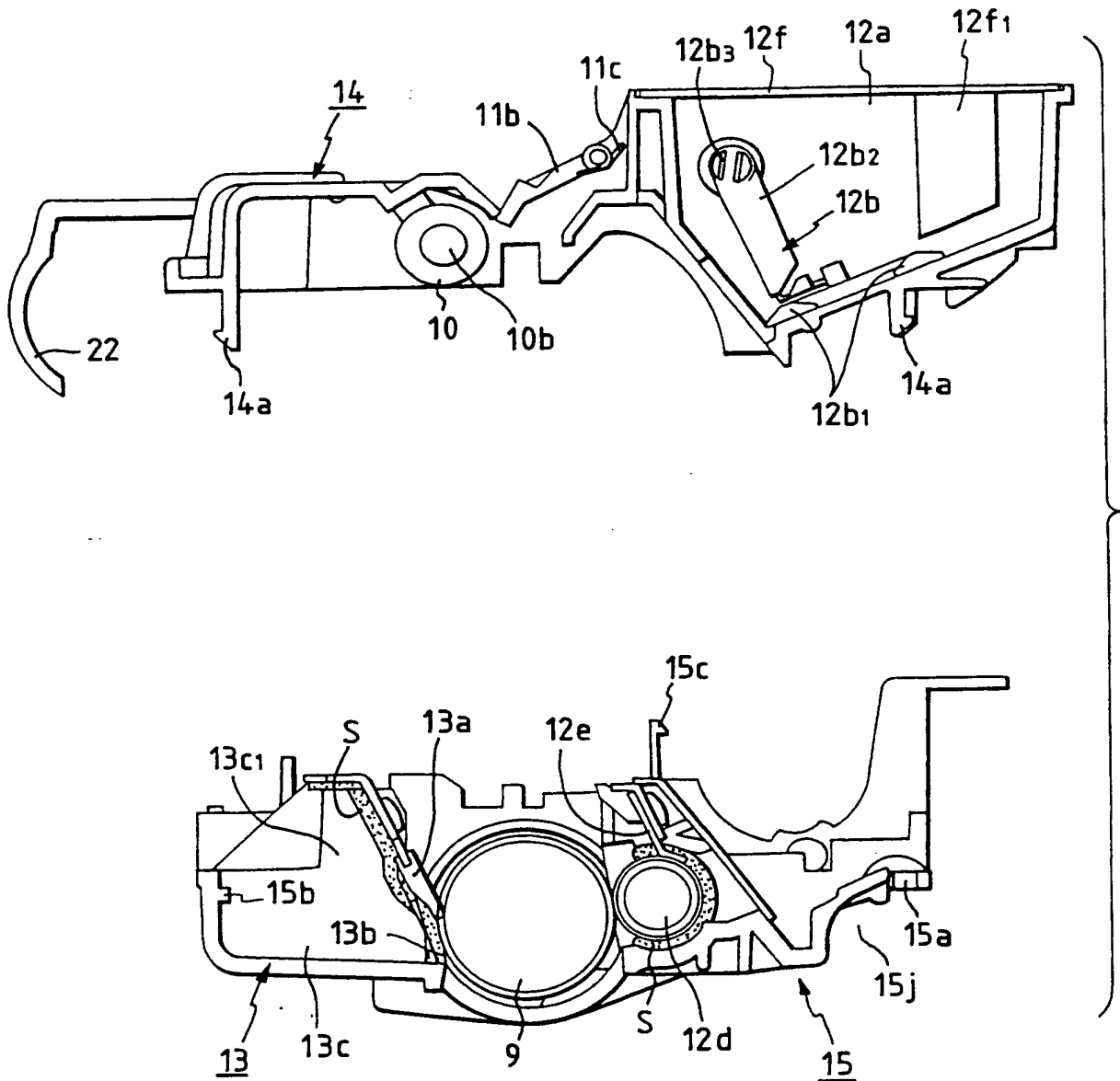




FIG. 8

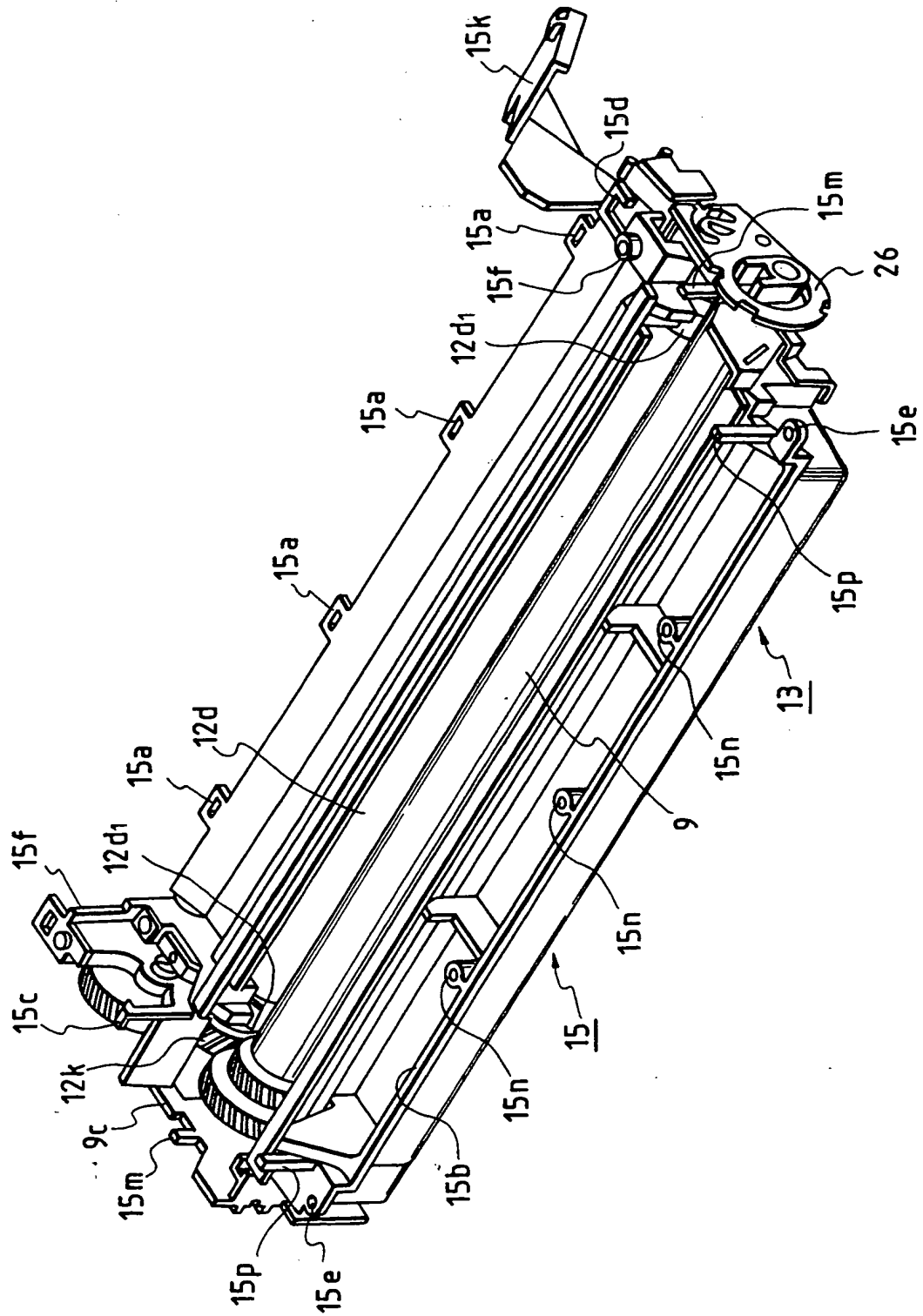


FIG. 9

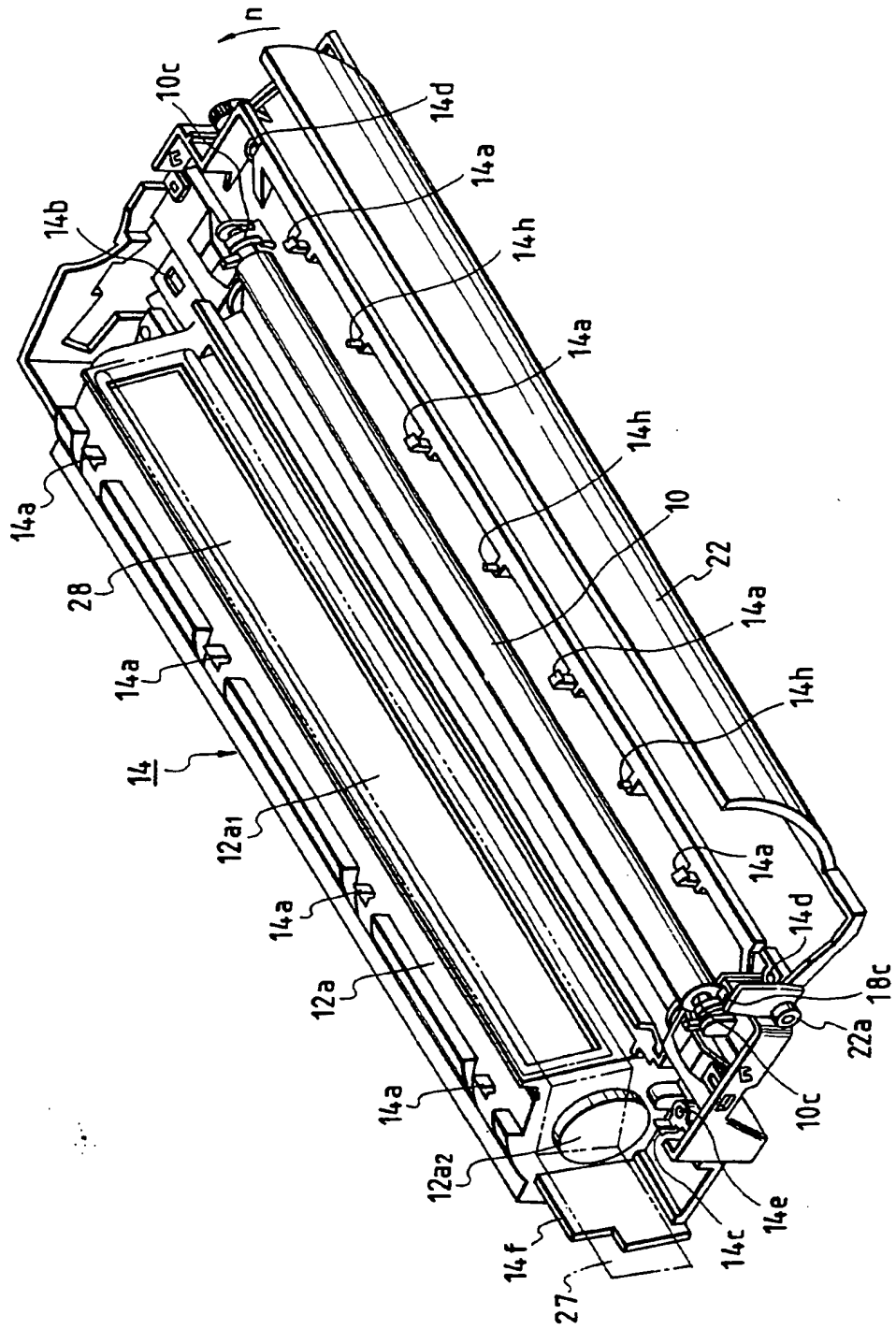


FIG. 10

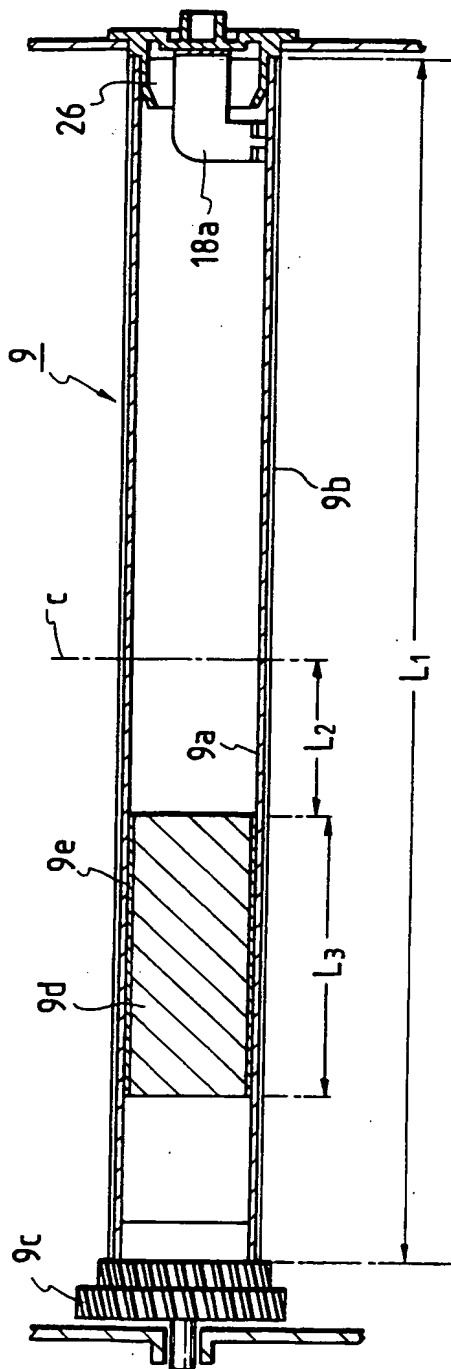
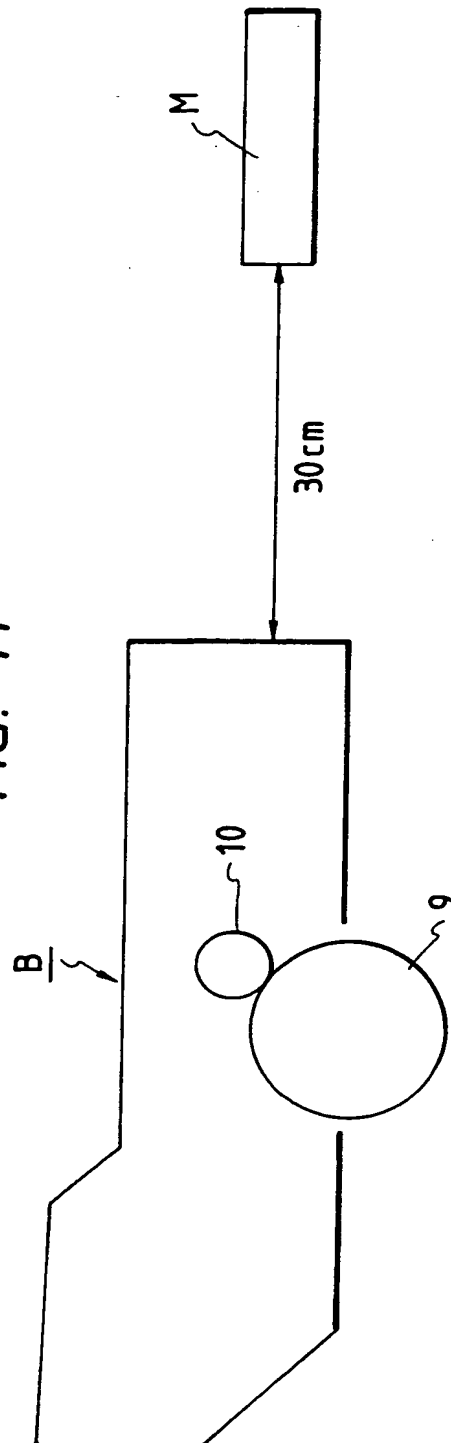
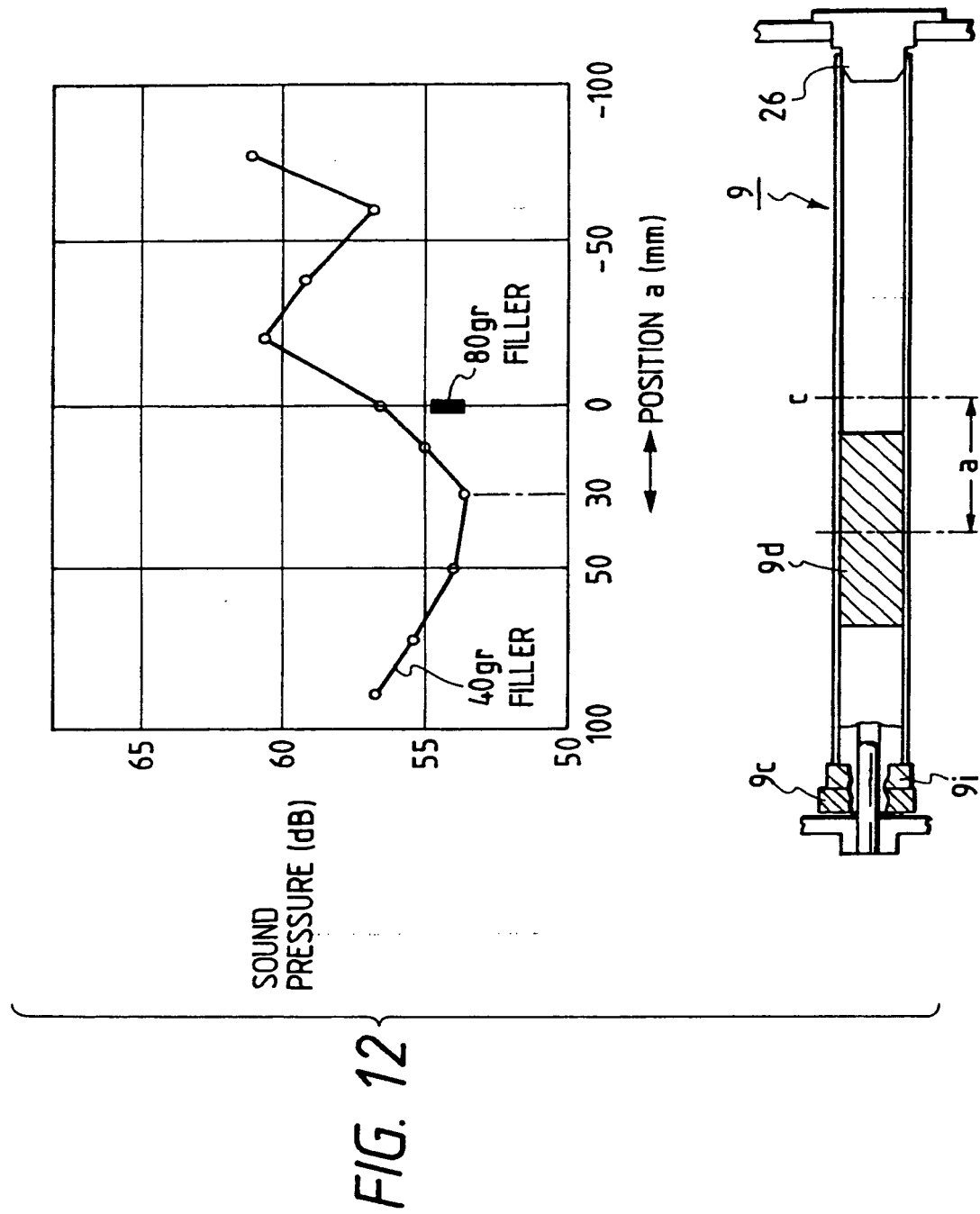
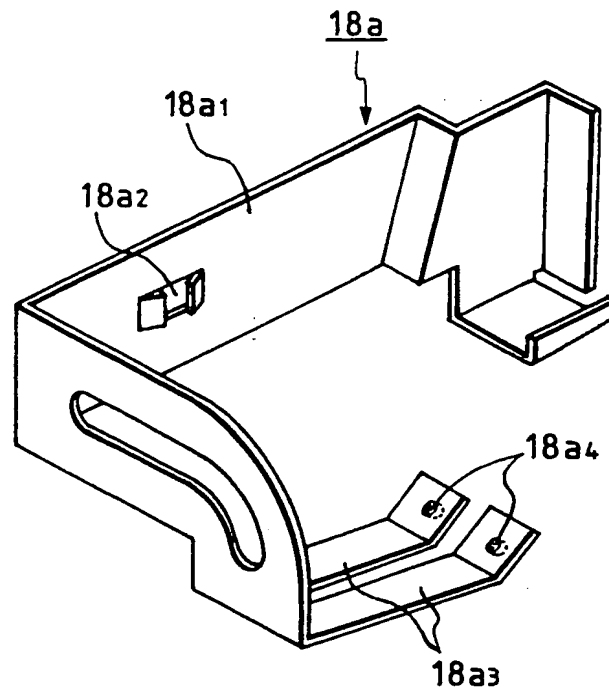


FIG. 11





*FIG. 13*



*FIG. 14*

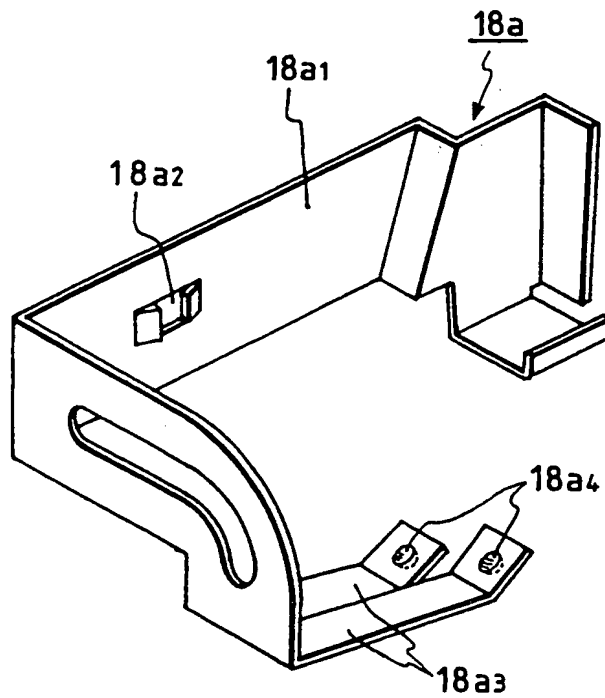


FIG. 15

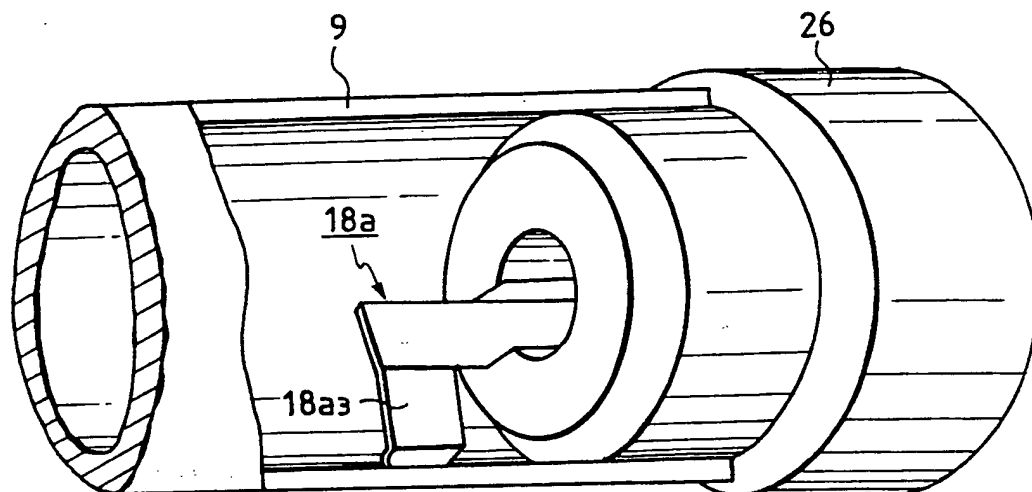


FIG. 16

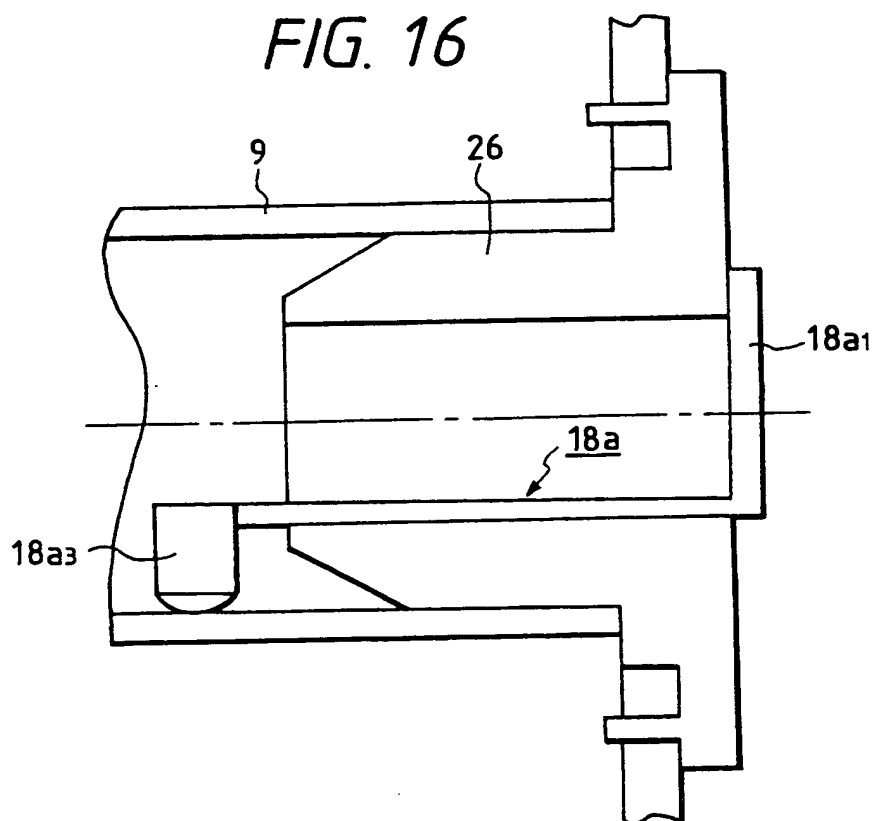


FIG. 17

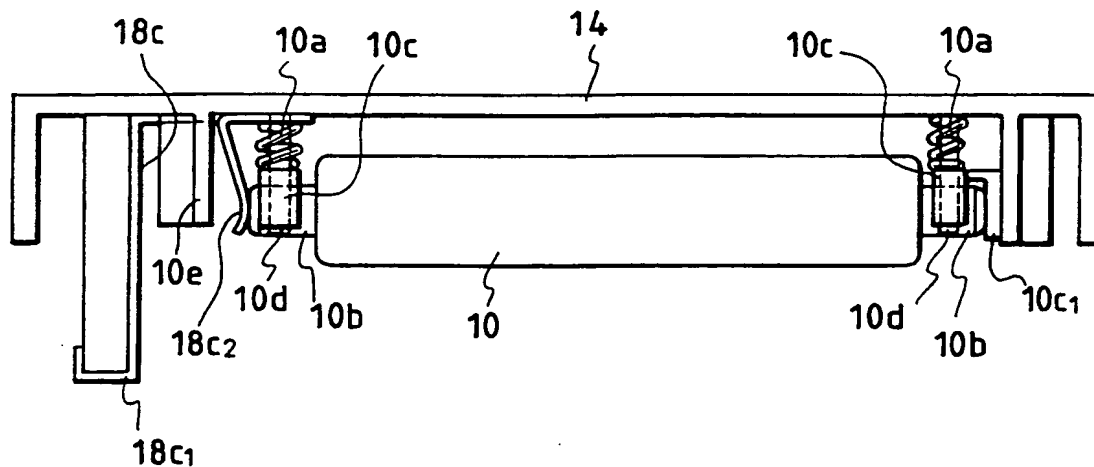


FIG. 18A

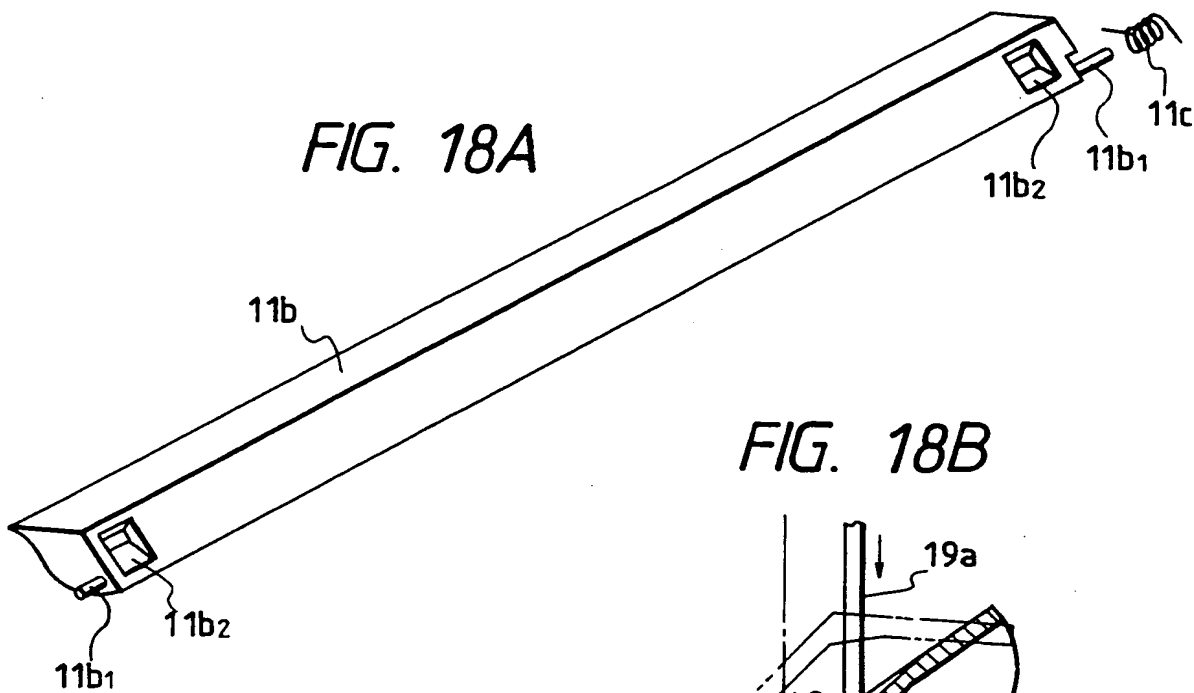


FIG. 18B

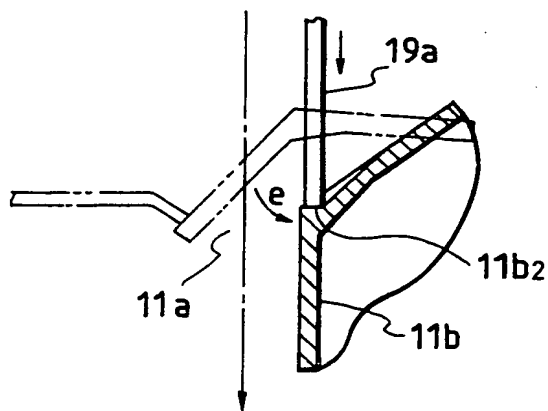


FIG. 19

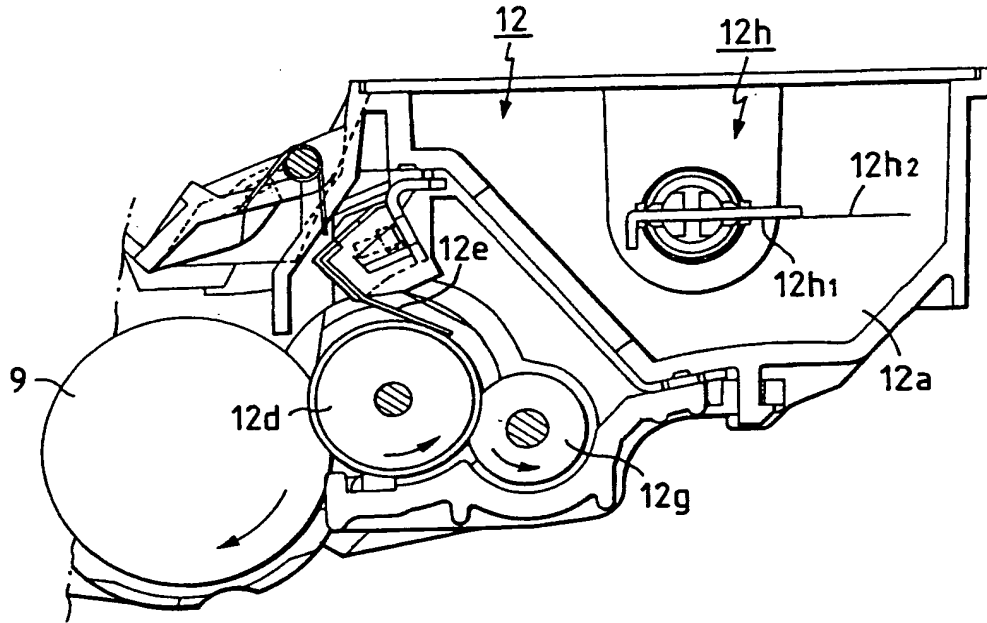


FIG. 20

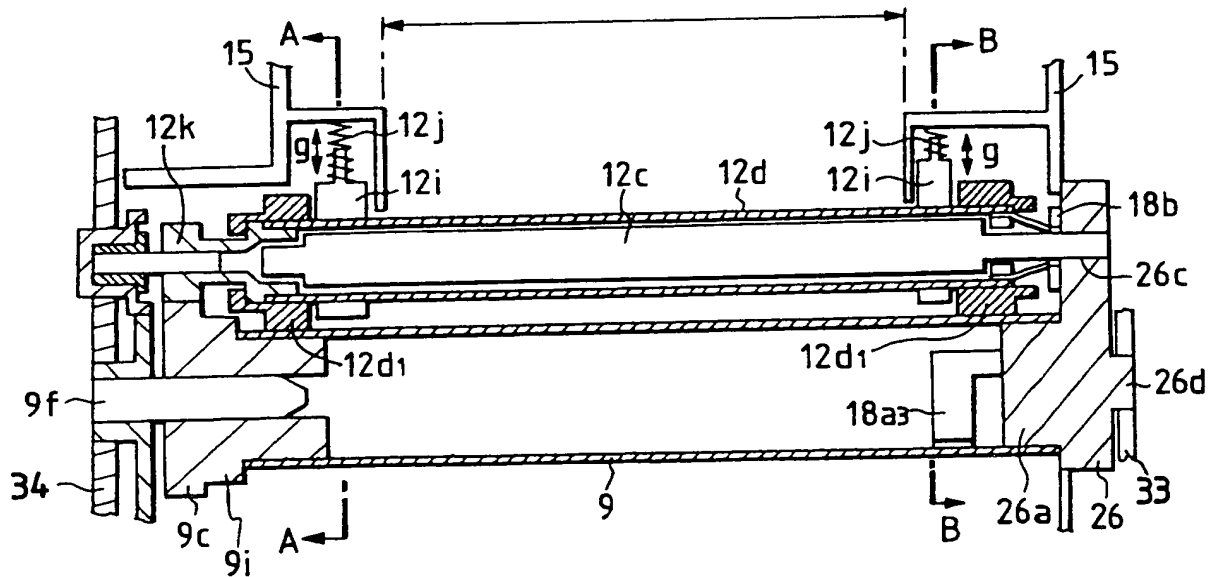




FIG. 21A

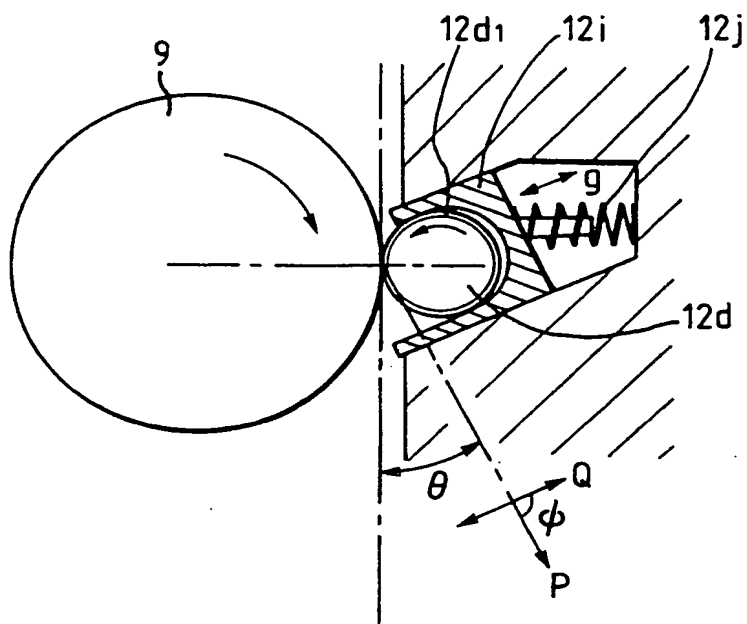


FIG. 21B

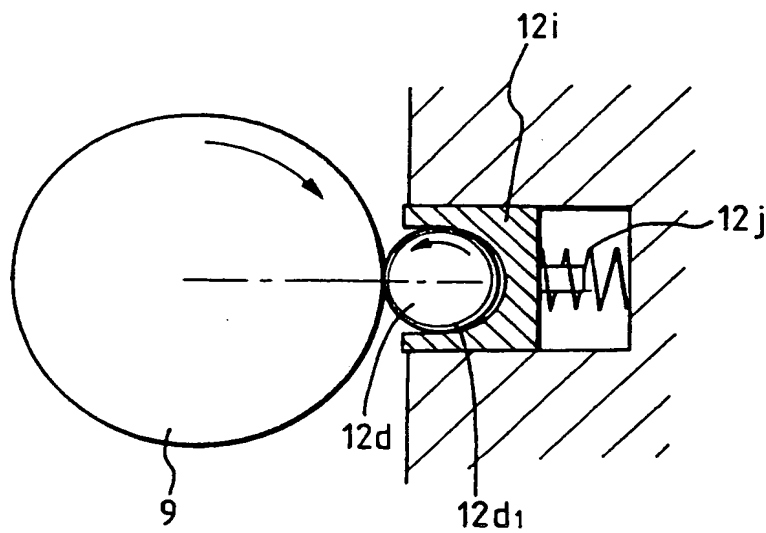


FIG. 22

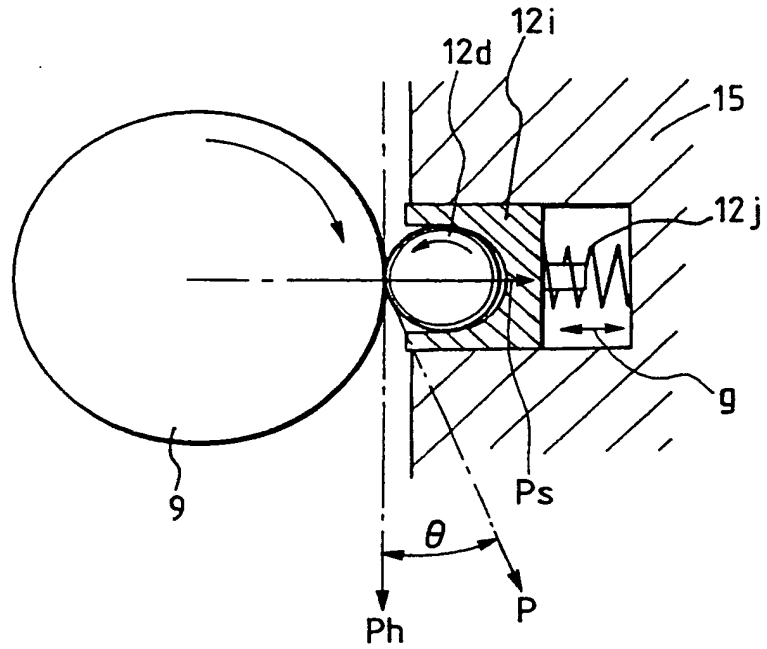


FIG. 23

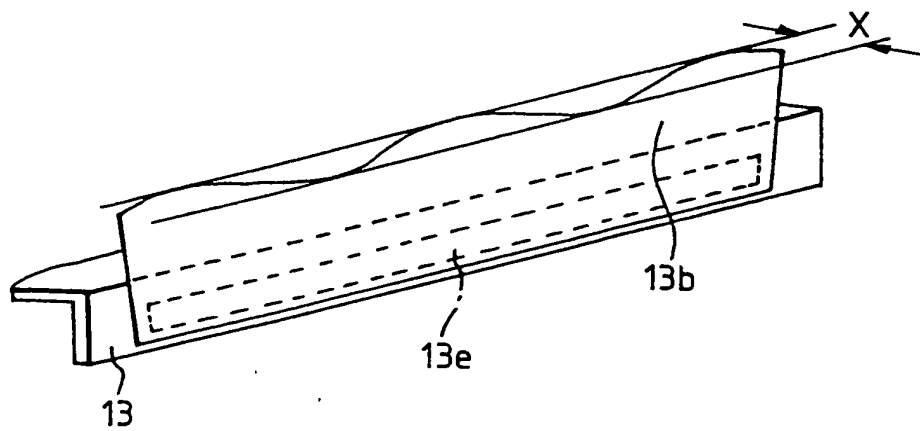


FIG. 24A

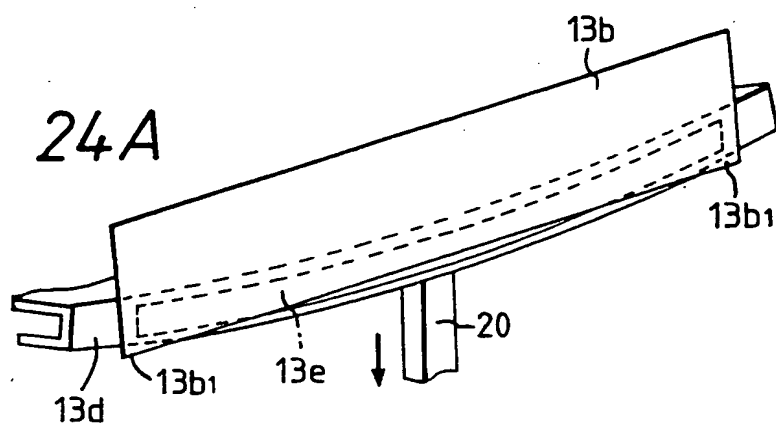


FIG. 24B

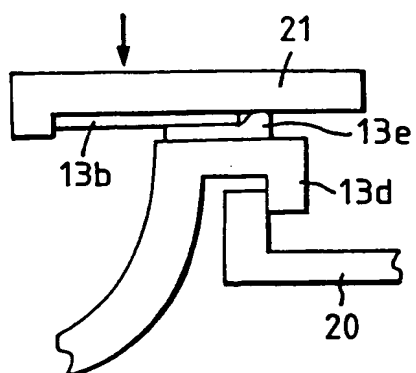
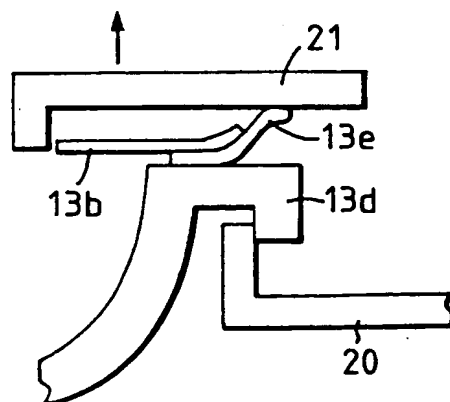


FIG. 24C



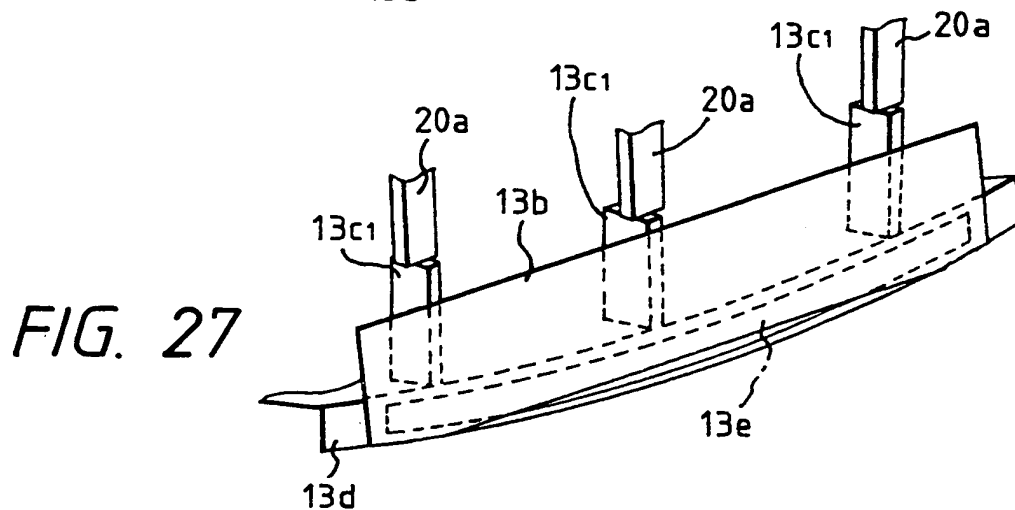
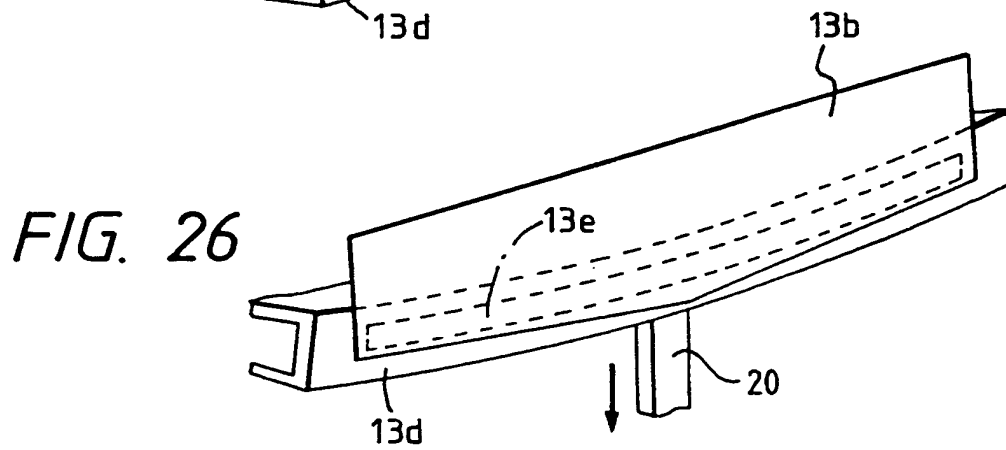
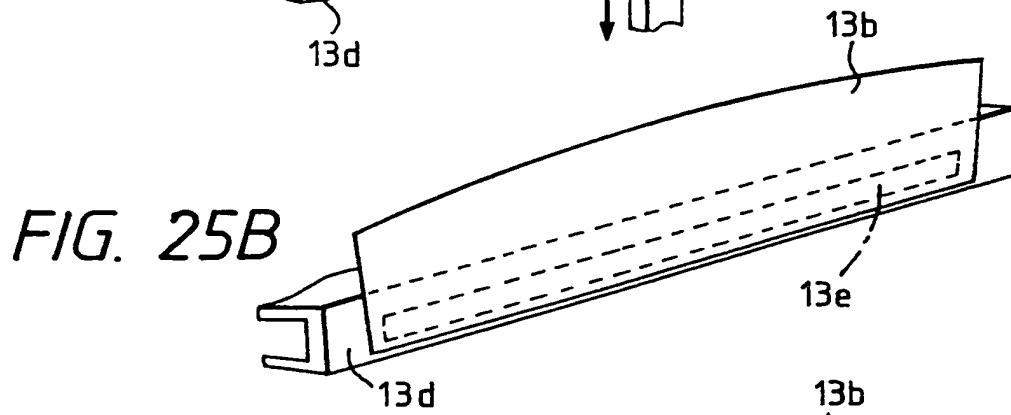
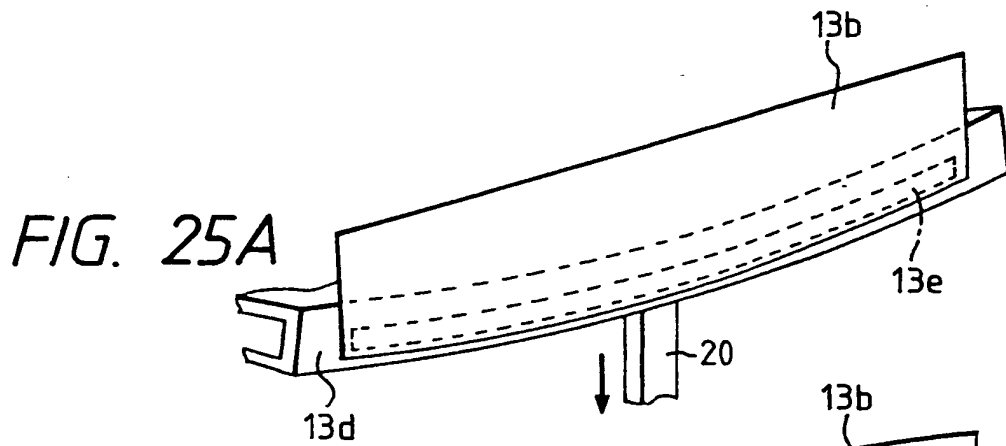


FIG. 28

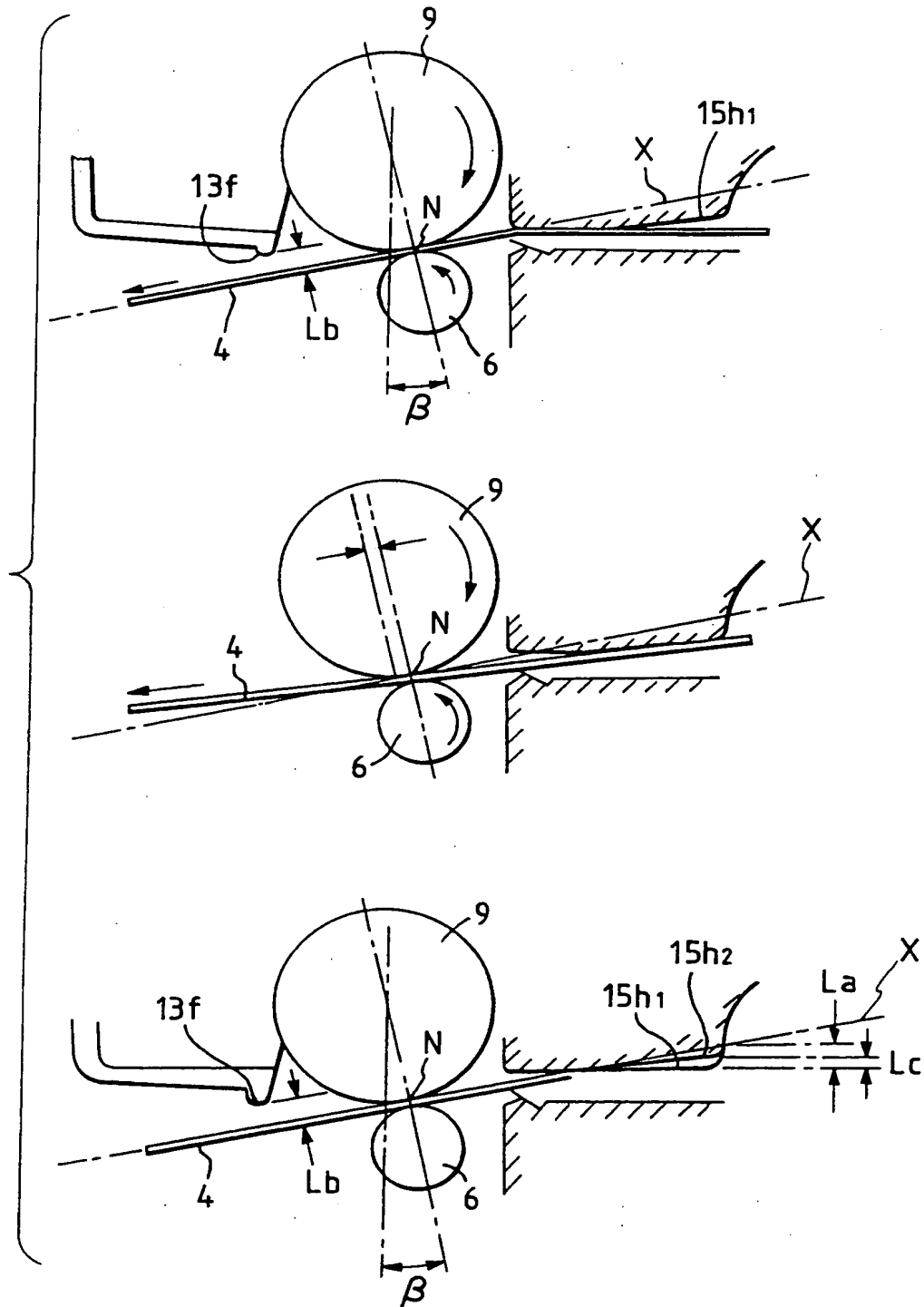


FIG. 29

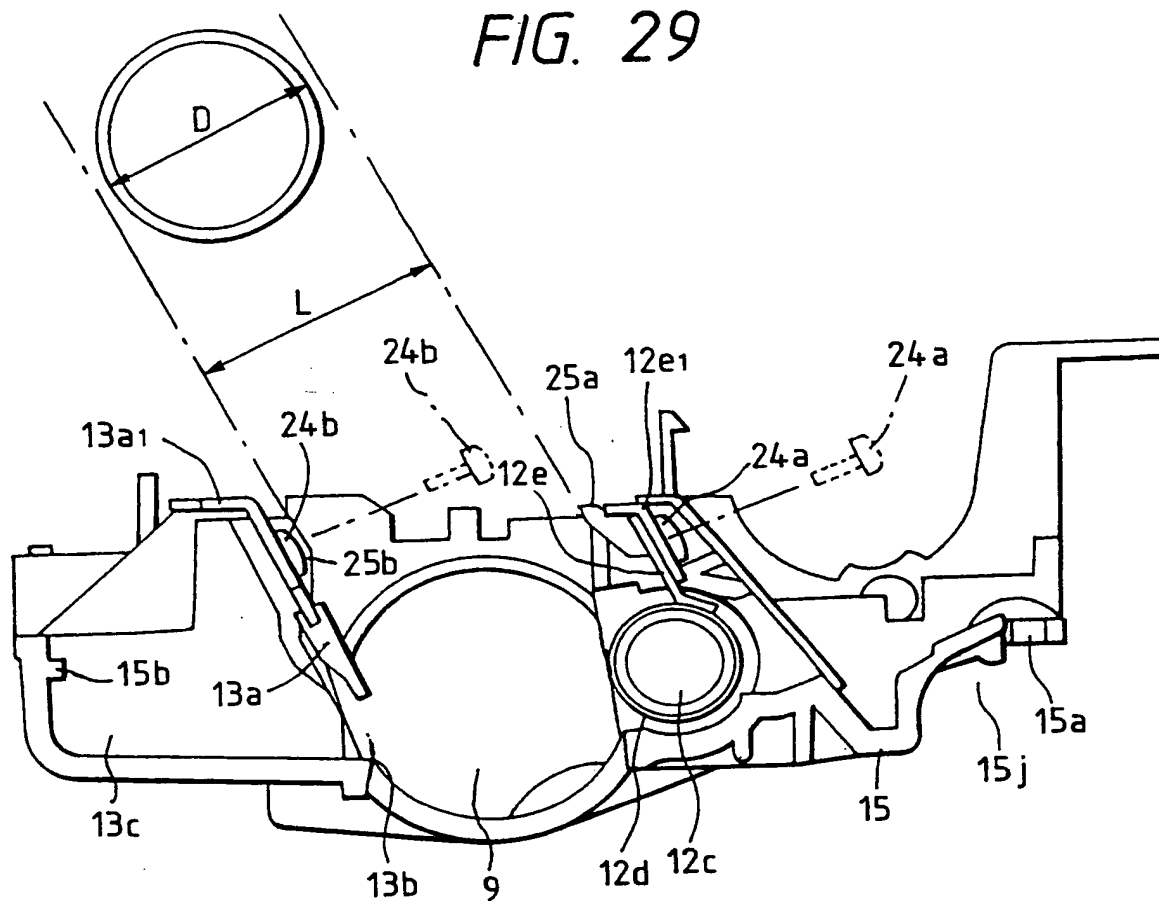


FIG. 30

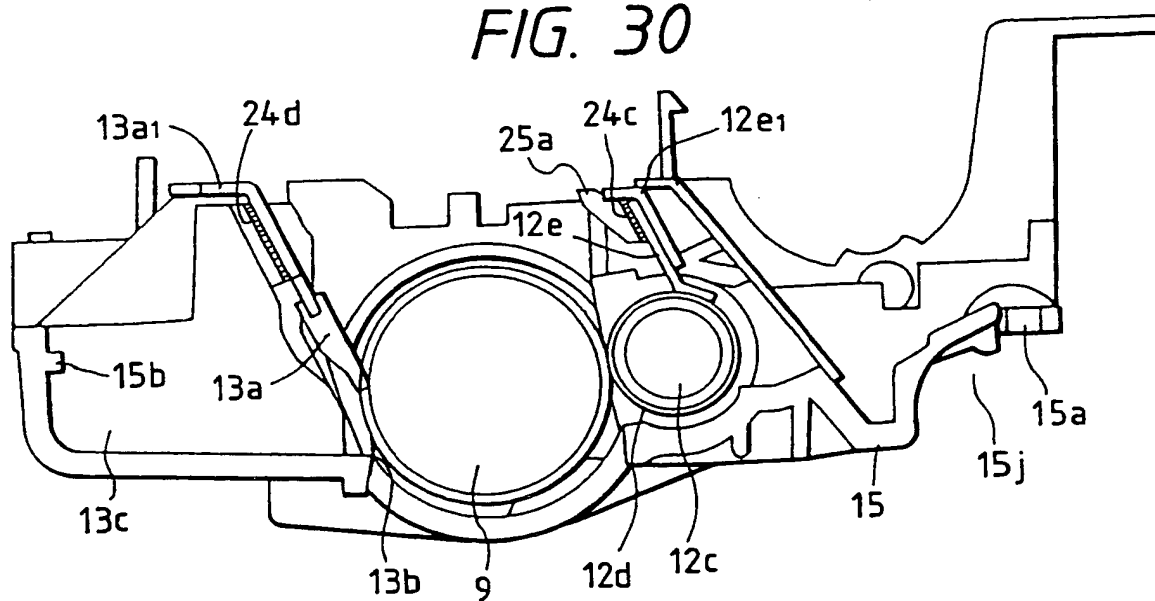


FIG. 31

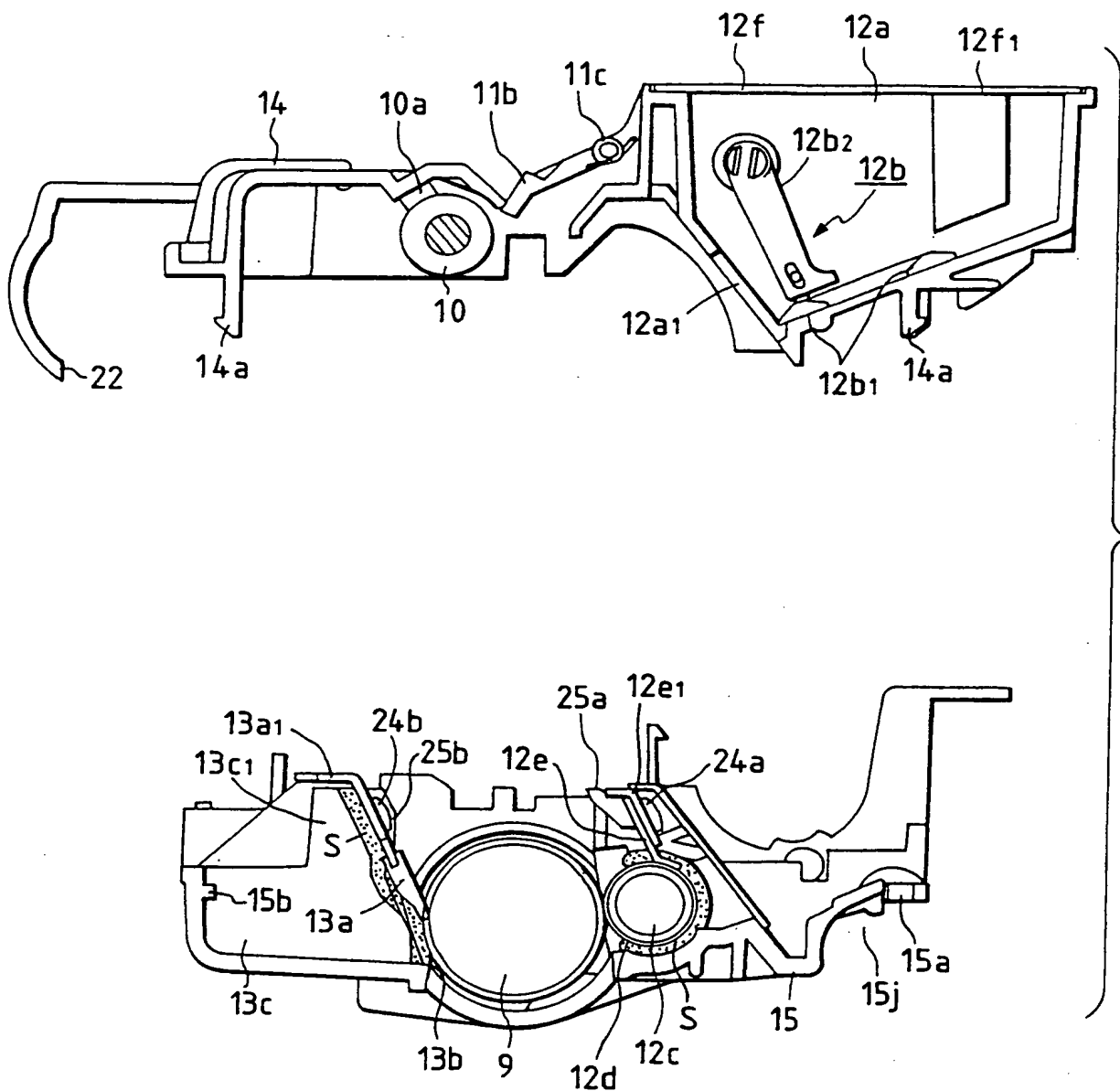


FIG. 32

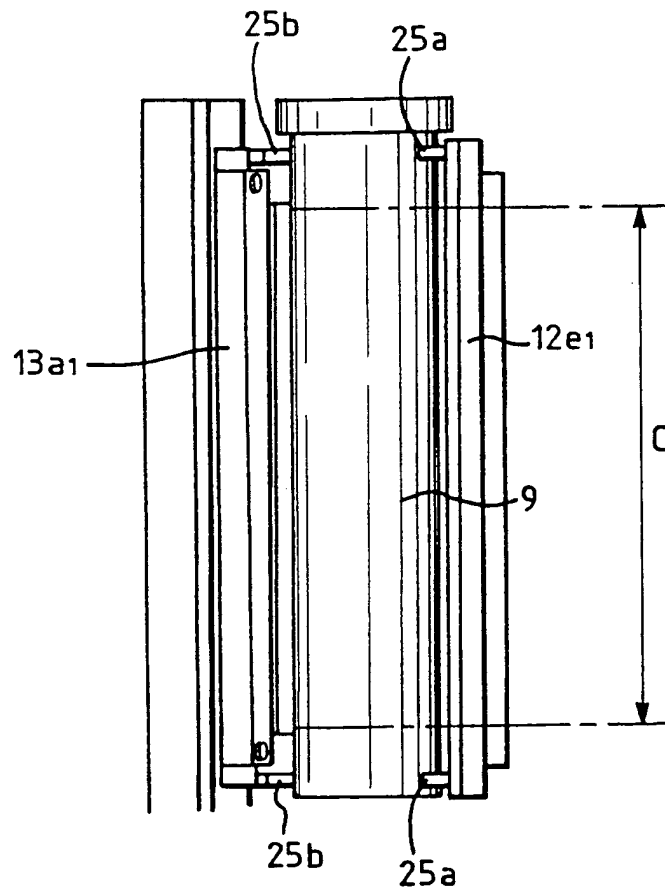
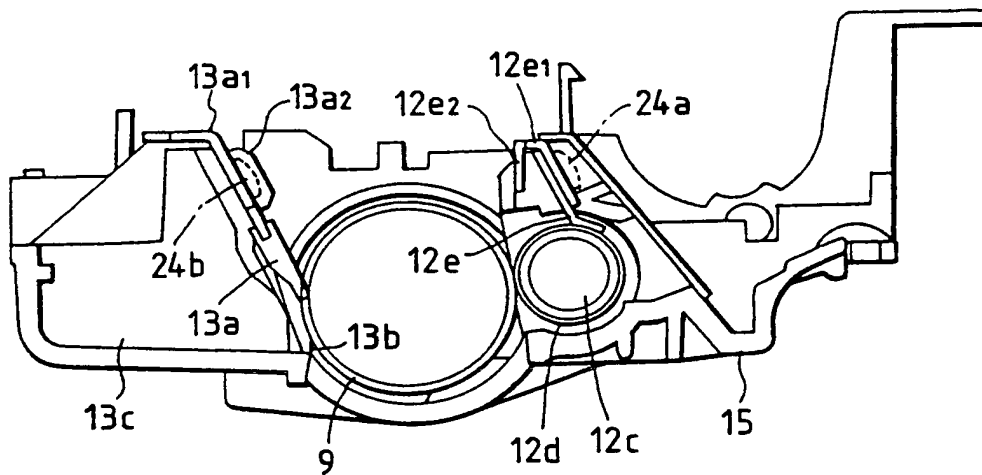


FIG. 33





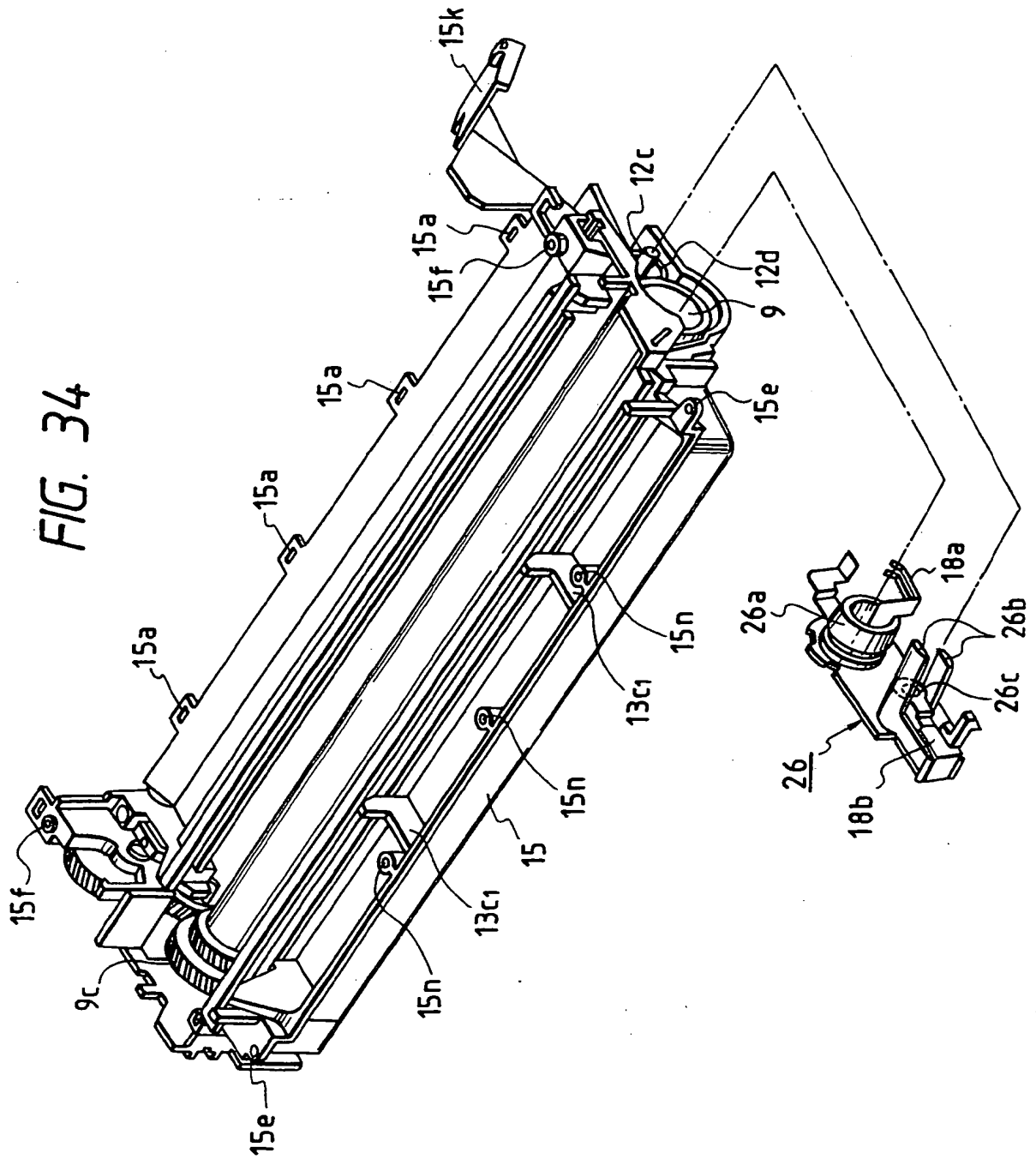


FIG. 35

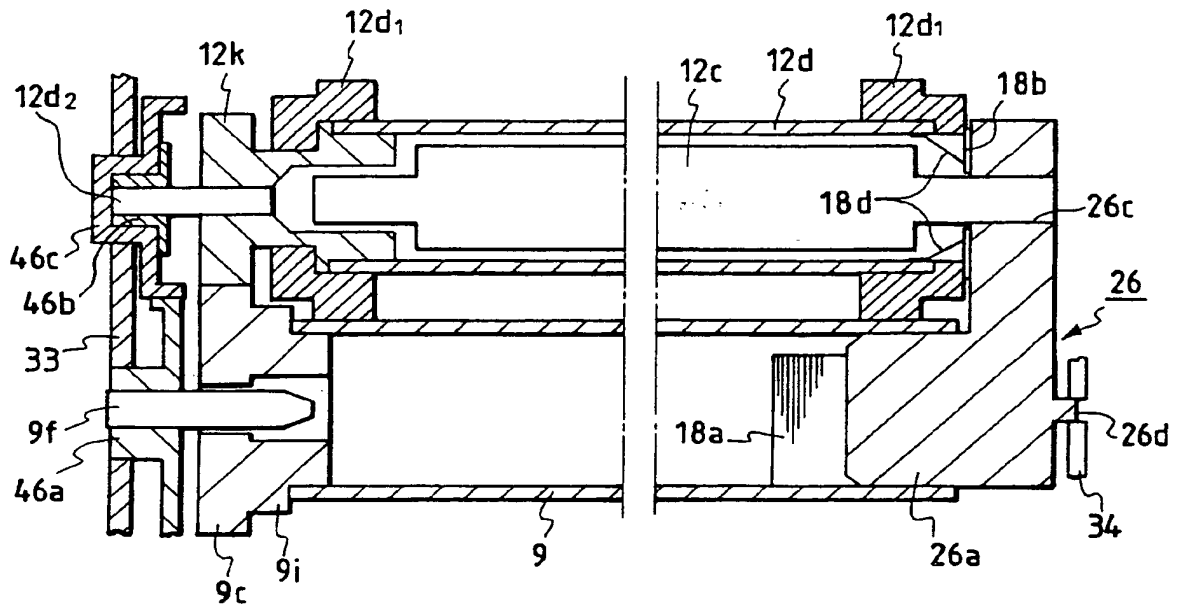


FIG. 36

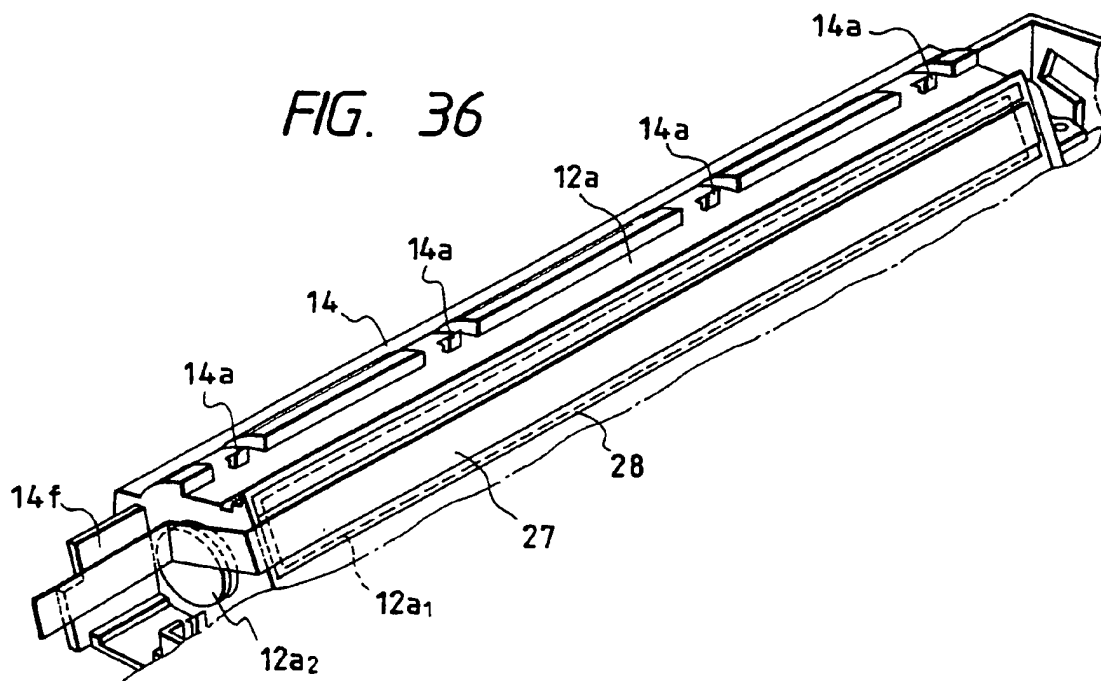


FIG. 37

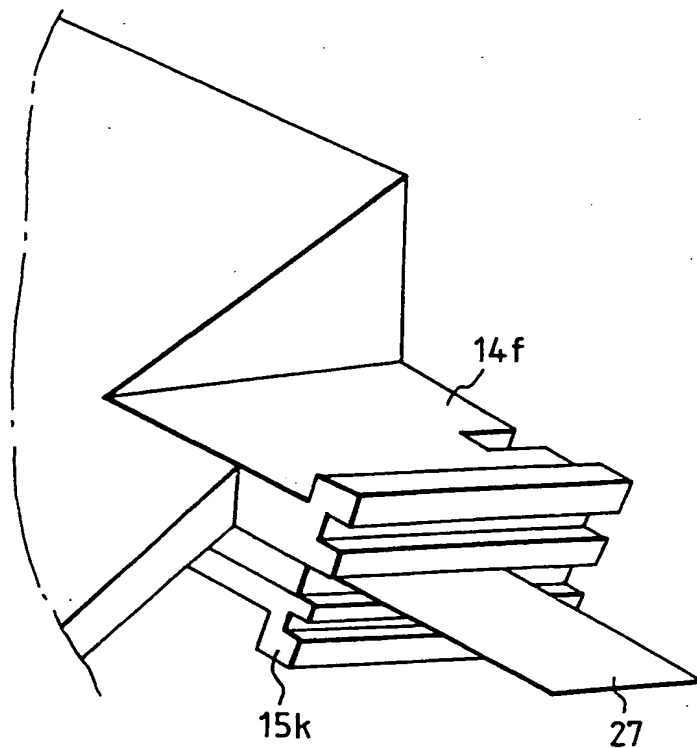


FIG. 38

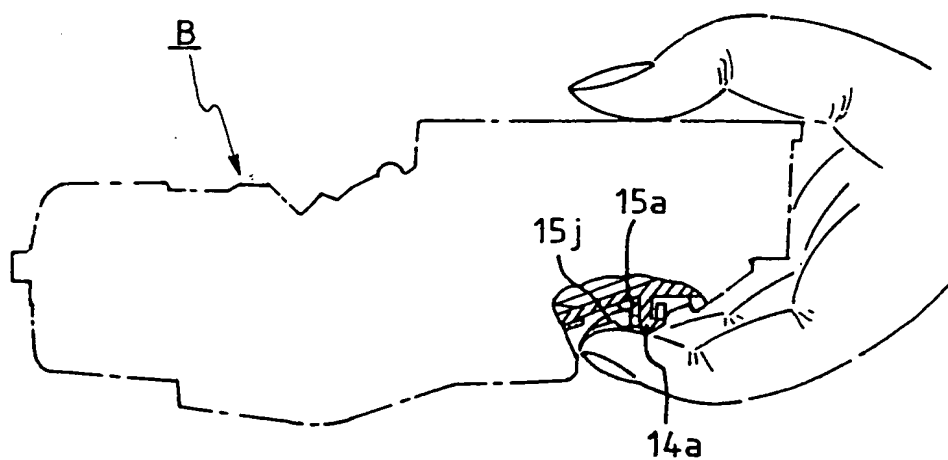


FIG. 39A

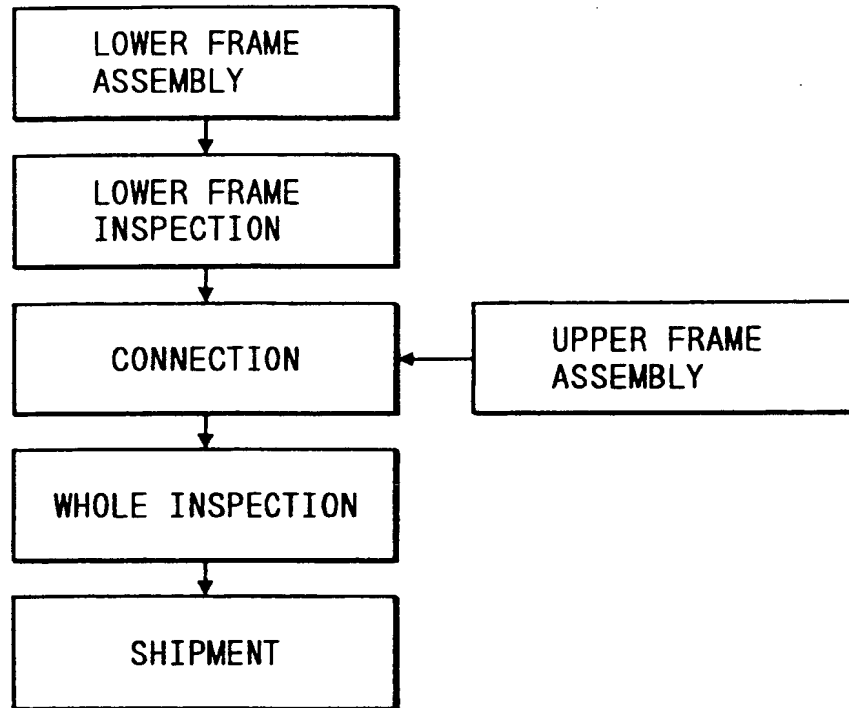


FIG. 39B

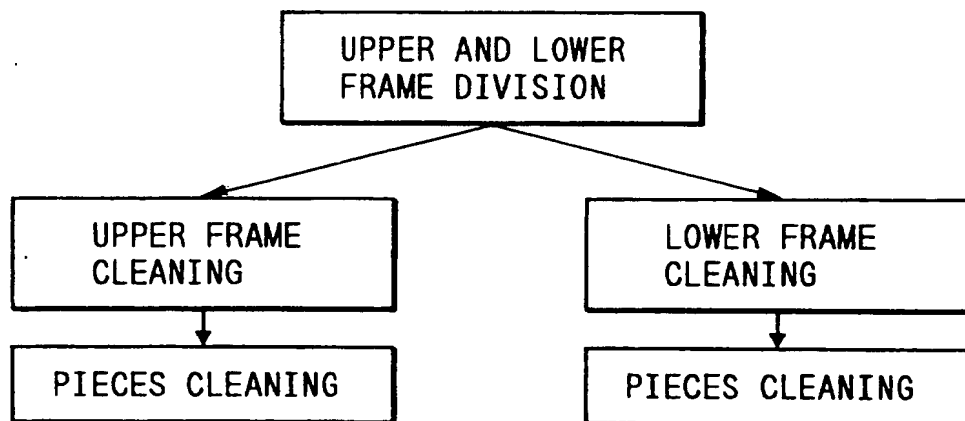


FIG. 40

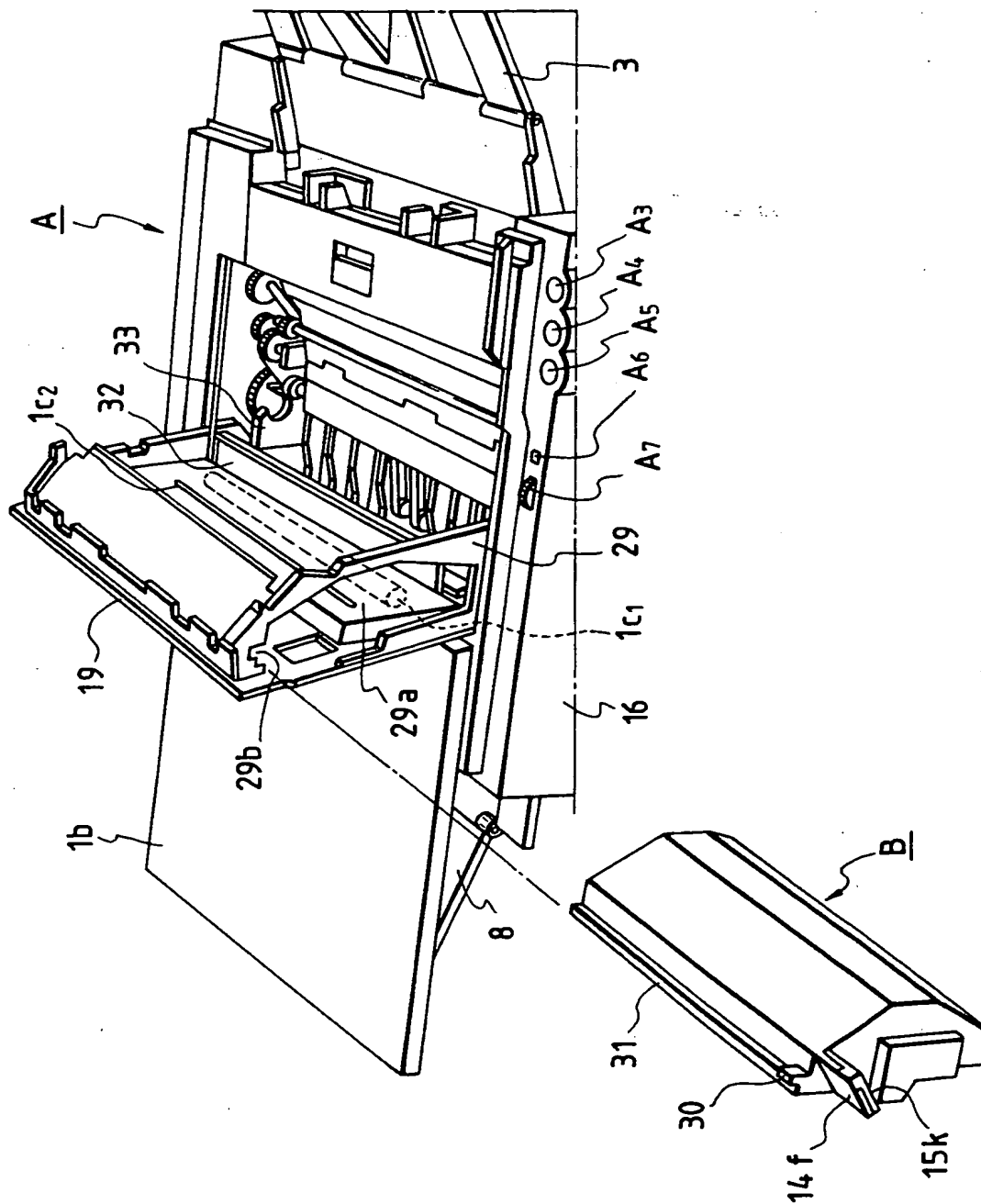


FIG. 41

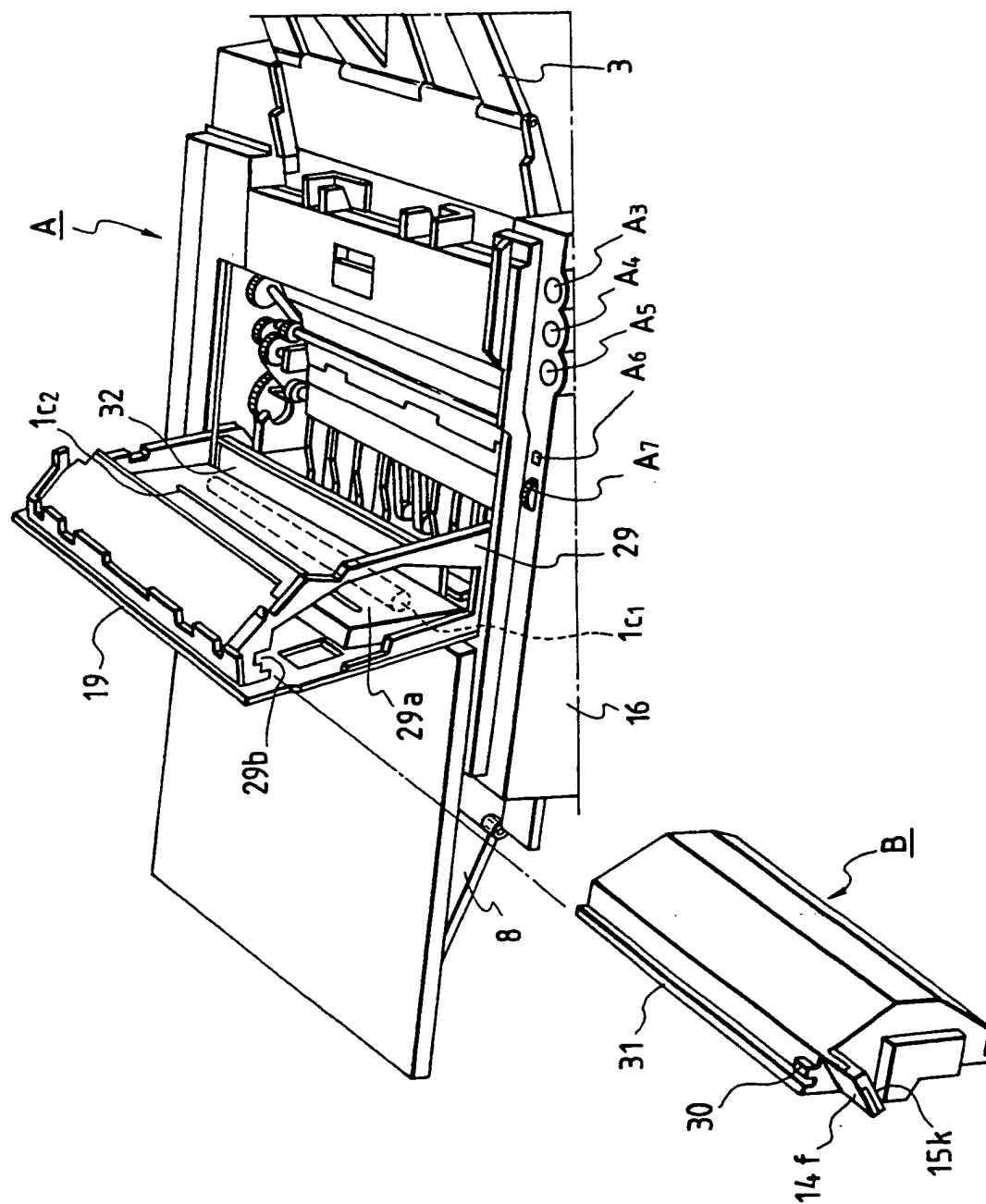


FIG. 42

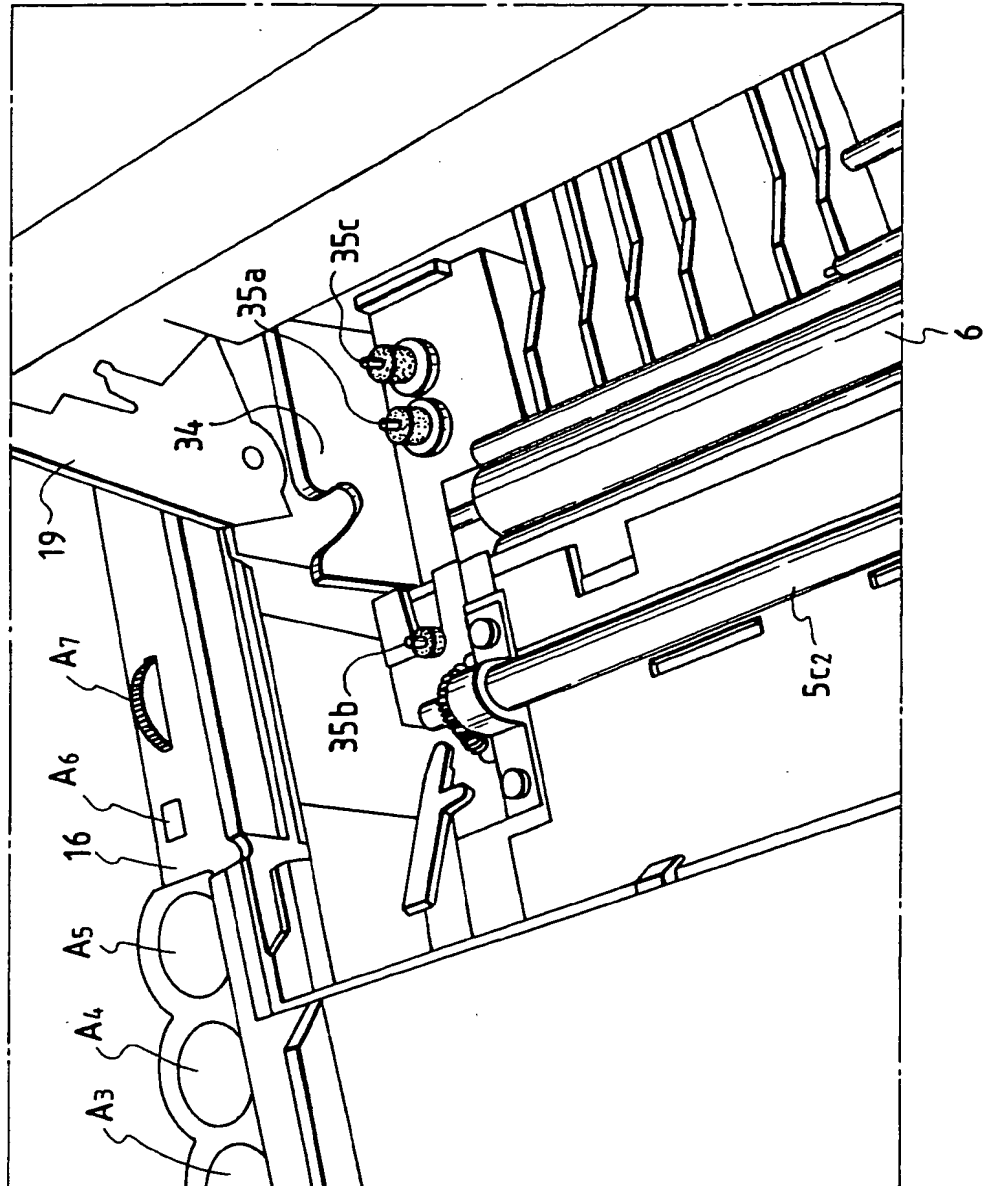


FIG. 43

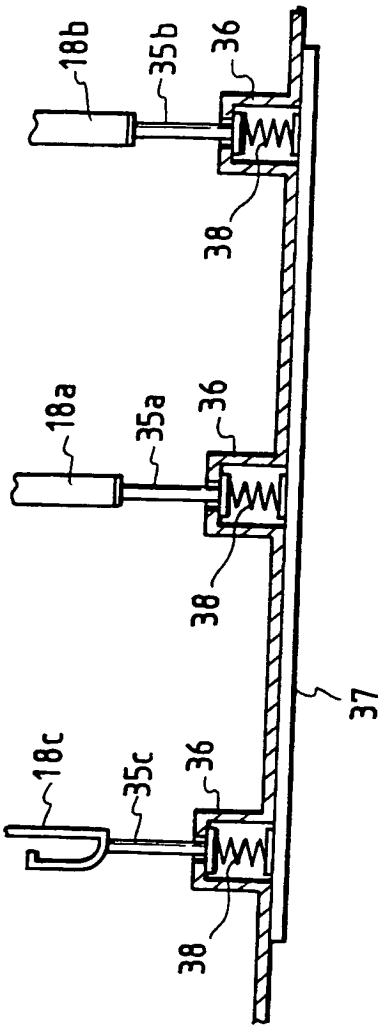
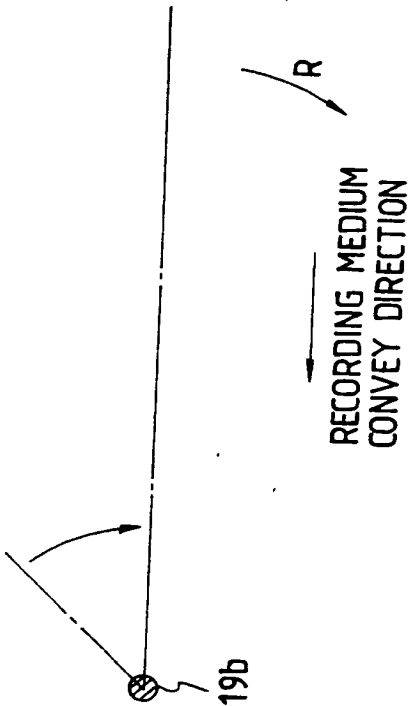




FIG. 44

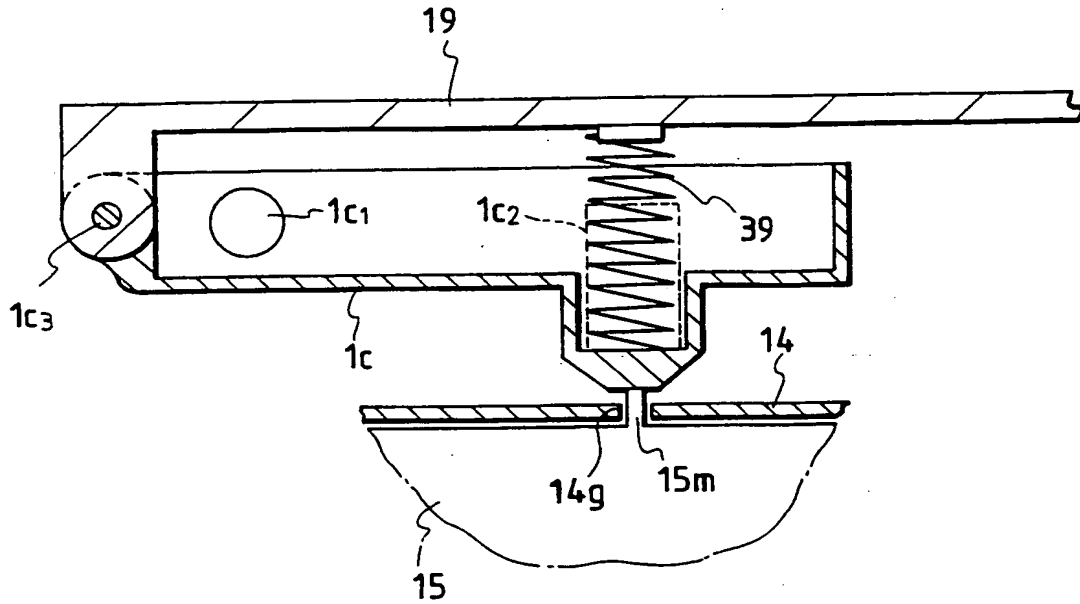


FIG. 45

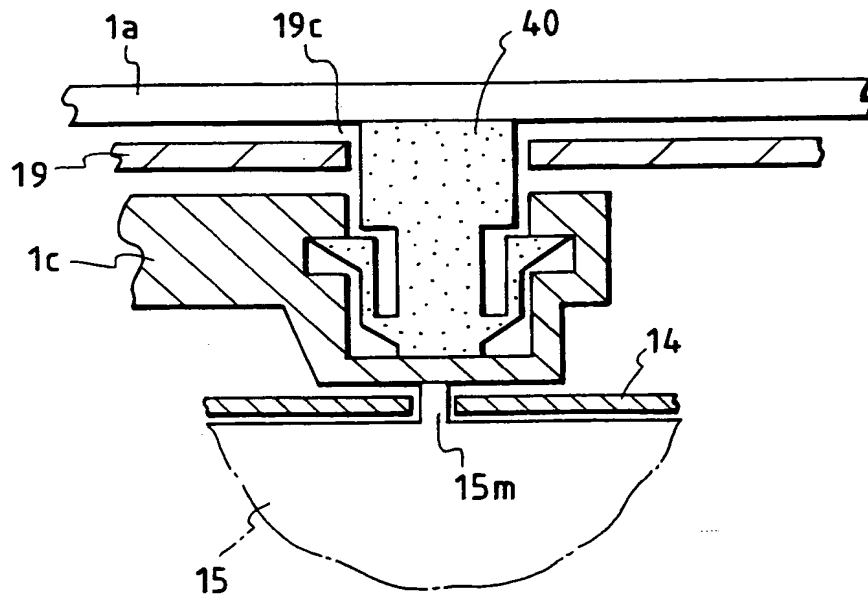


FIG. 46

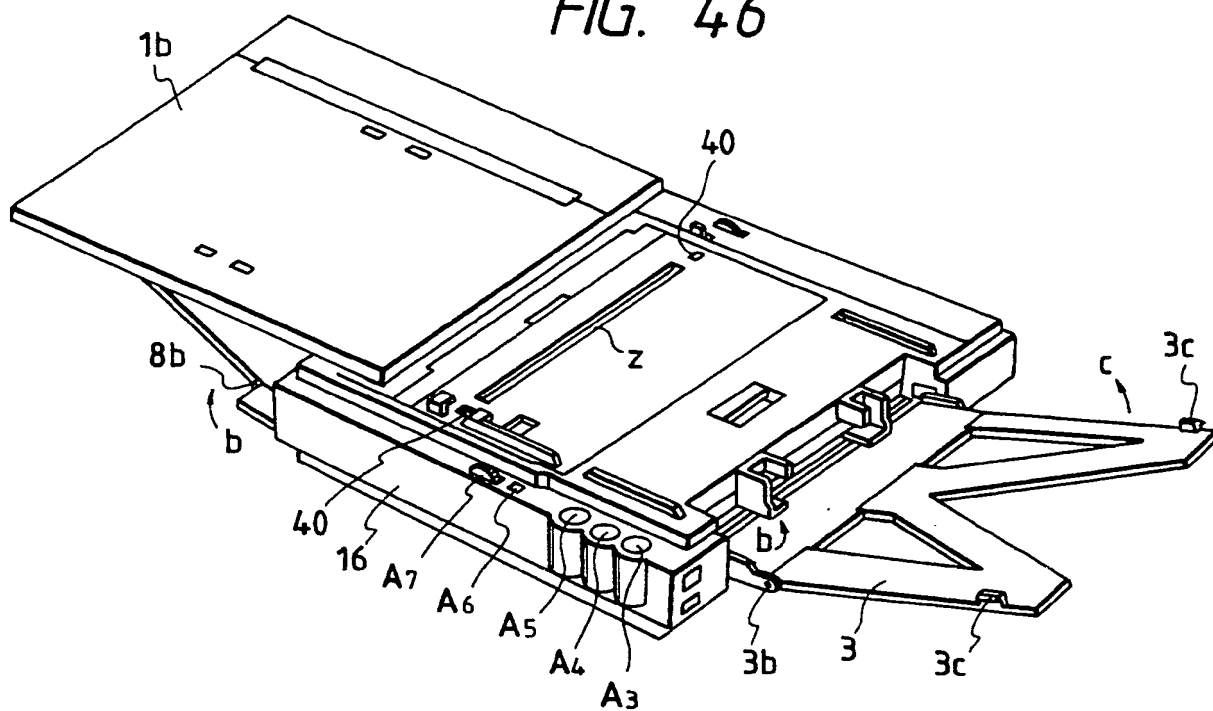


FIG. 47

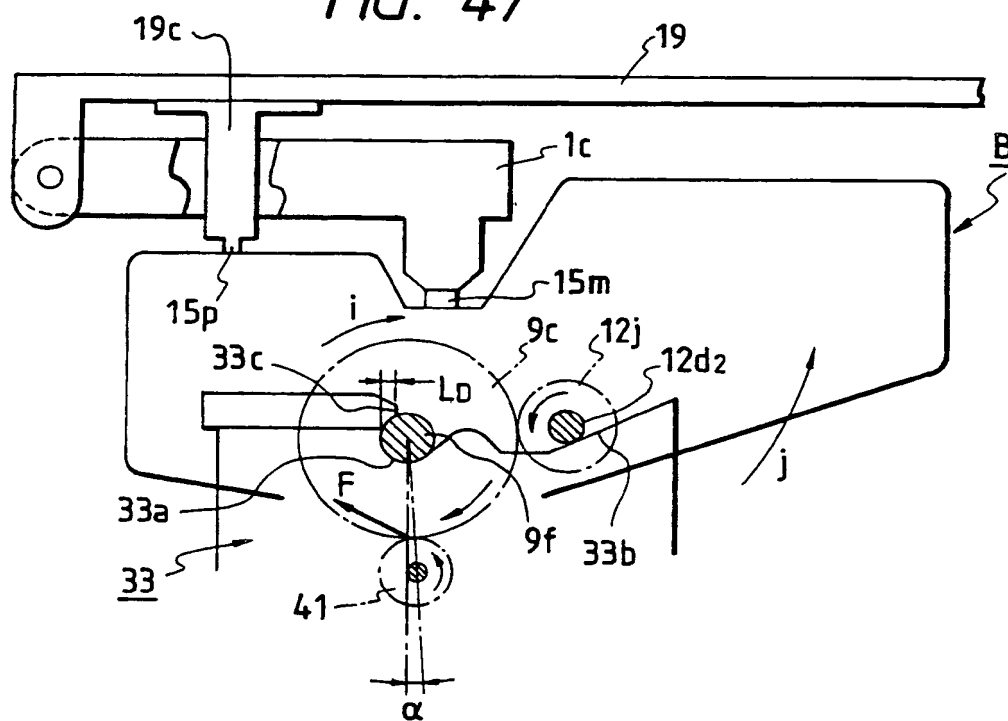


FIG. 48

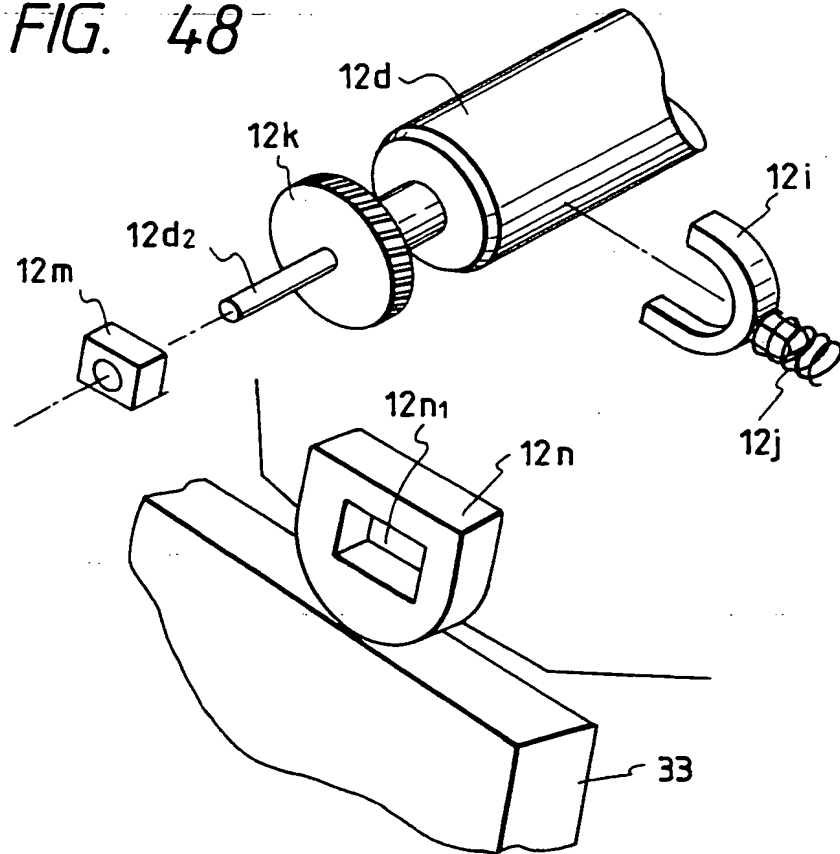


FIG. 49

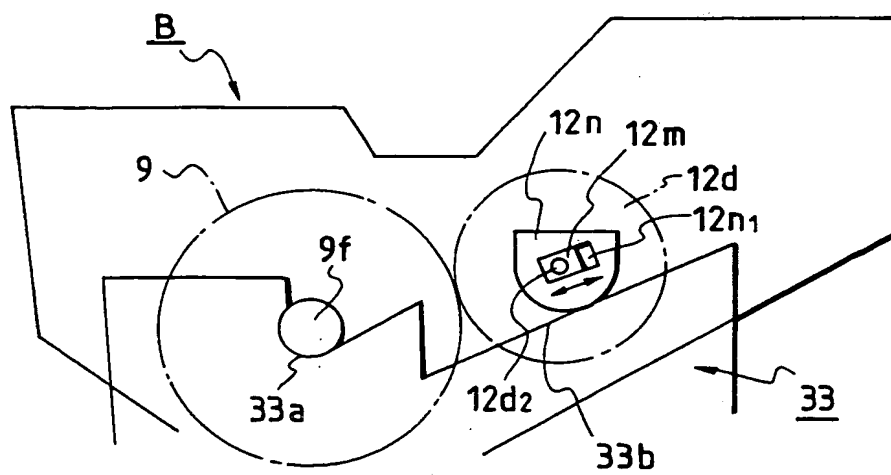


FIG. 50

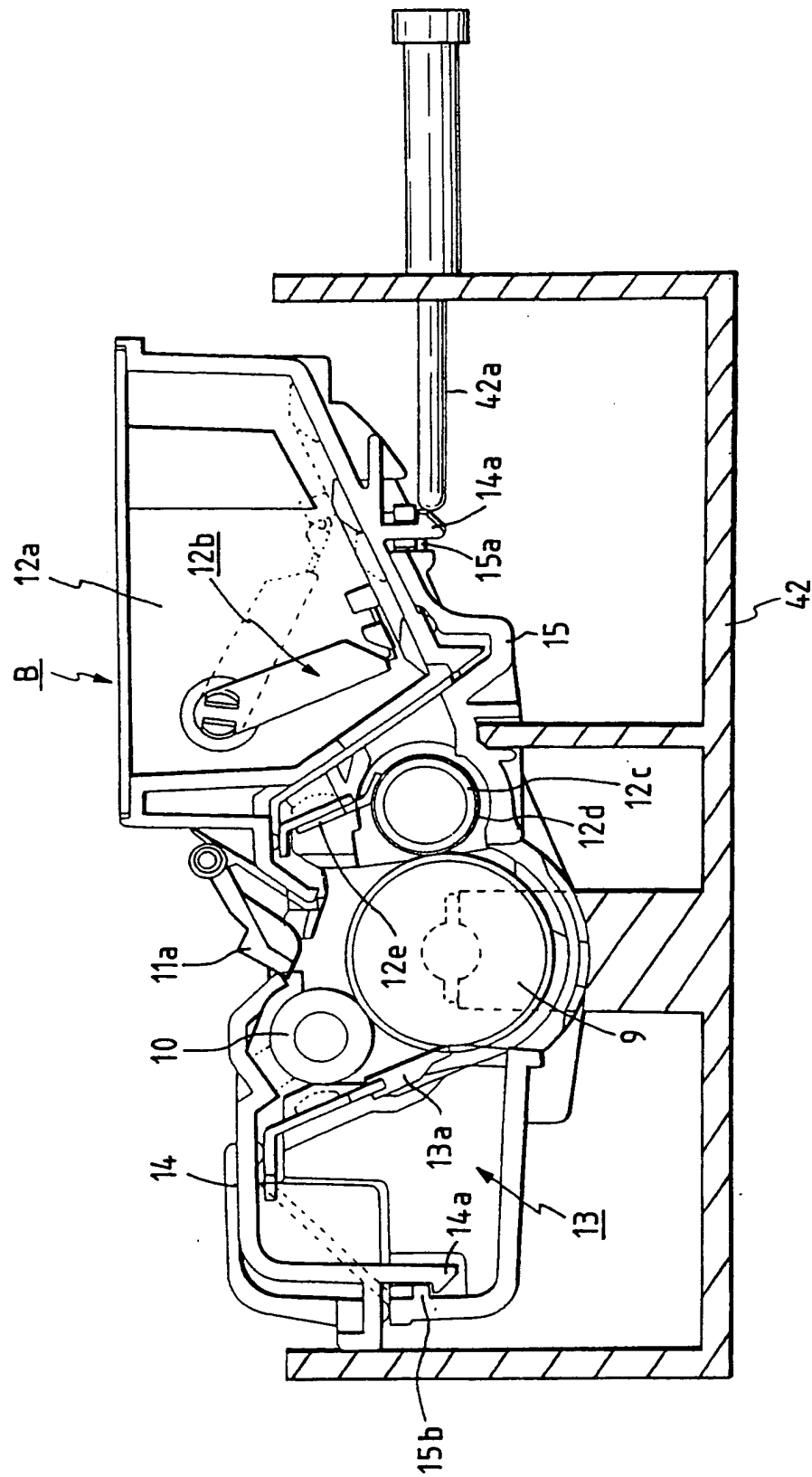


FIG. 51

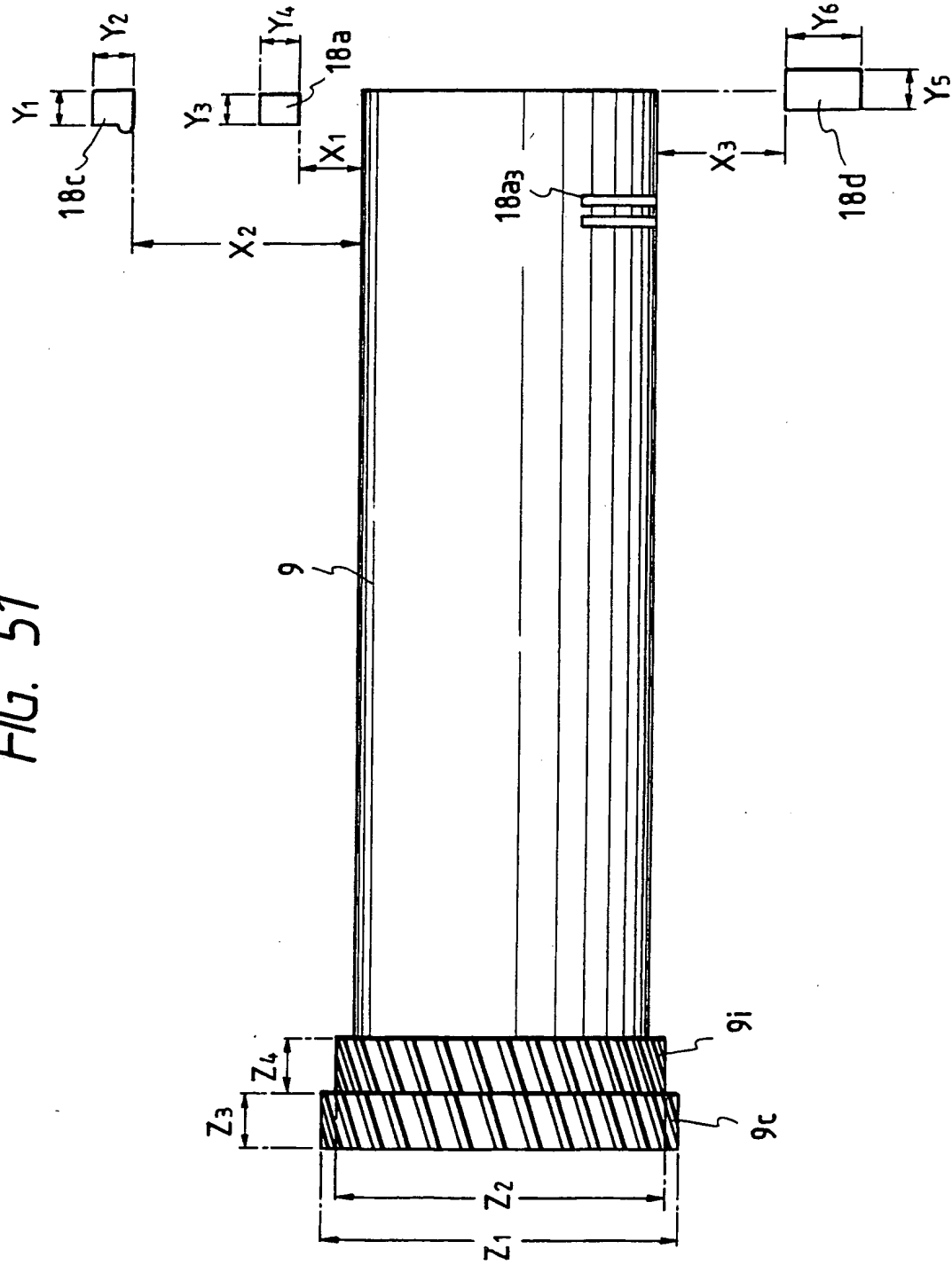


FIG. 52A

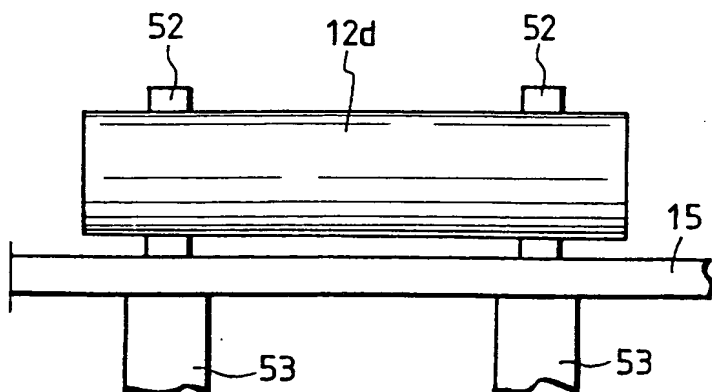


FIG. 52B

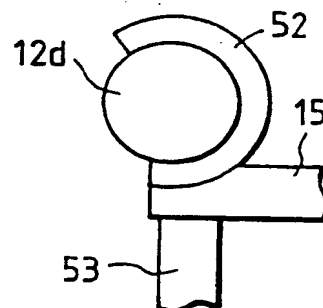


FIG. 53

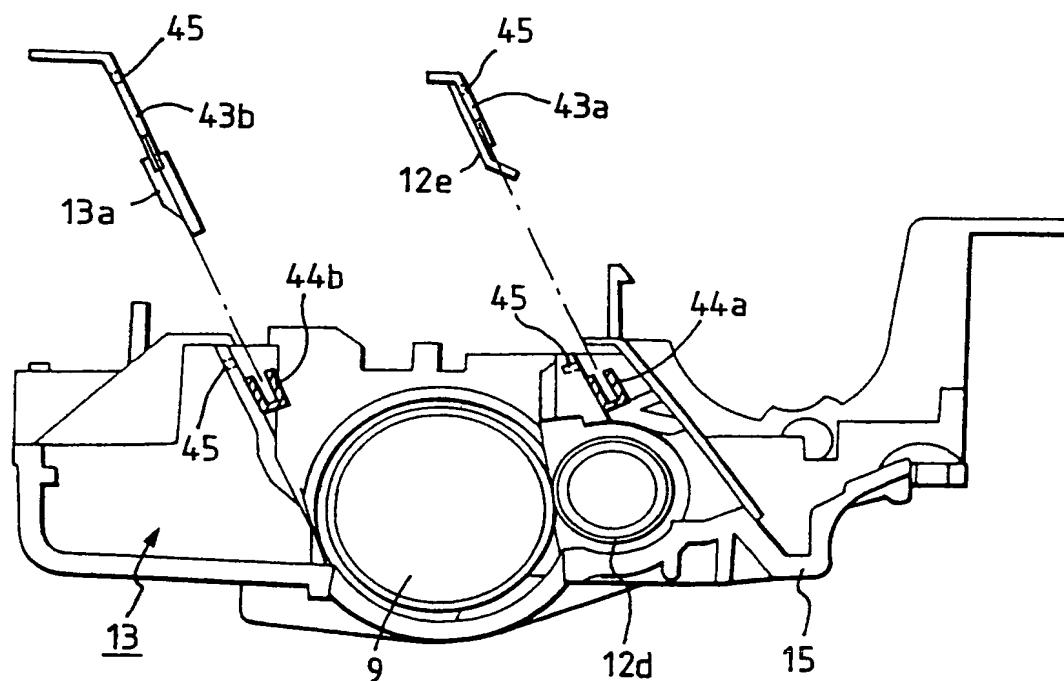


FIG. 54

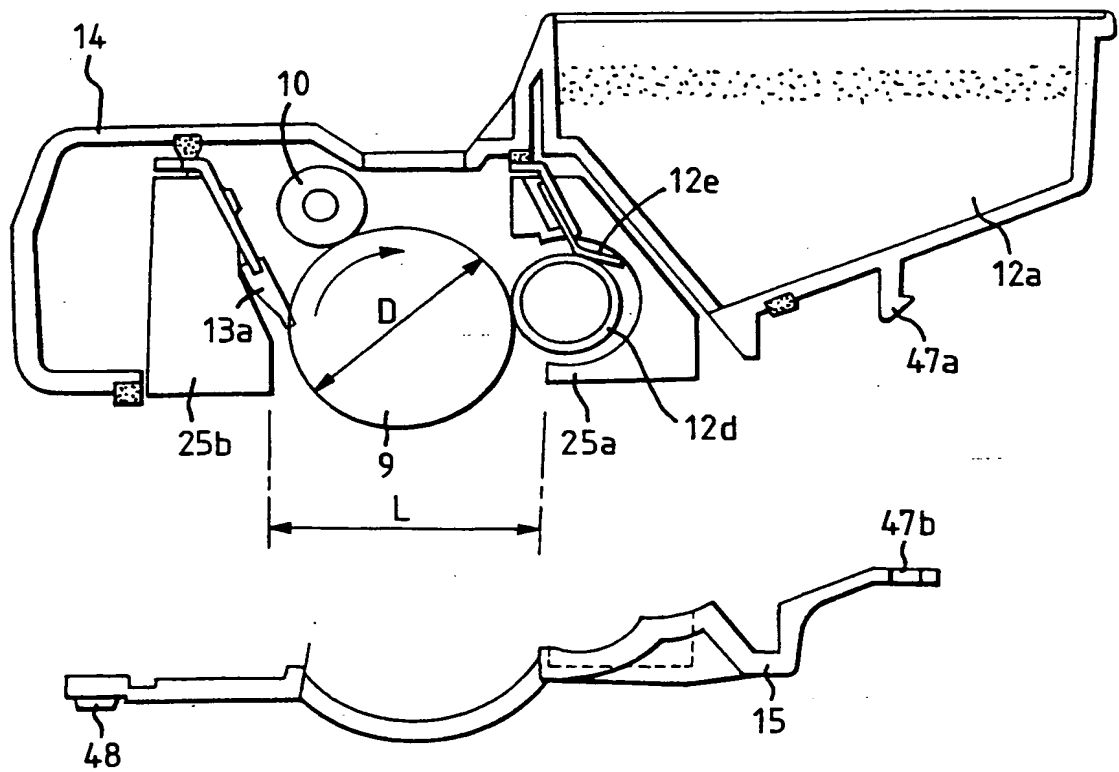


FIG. 55

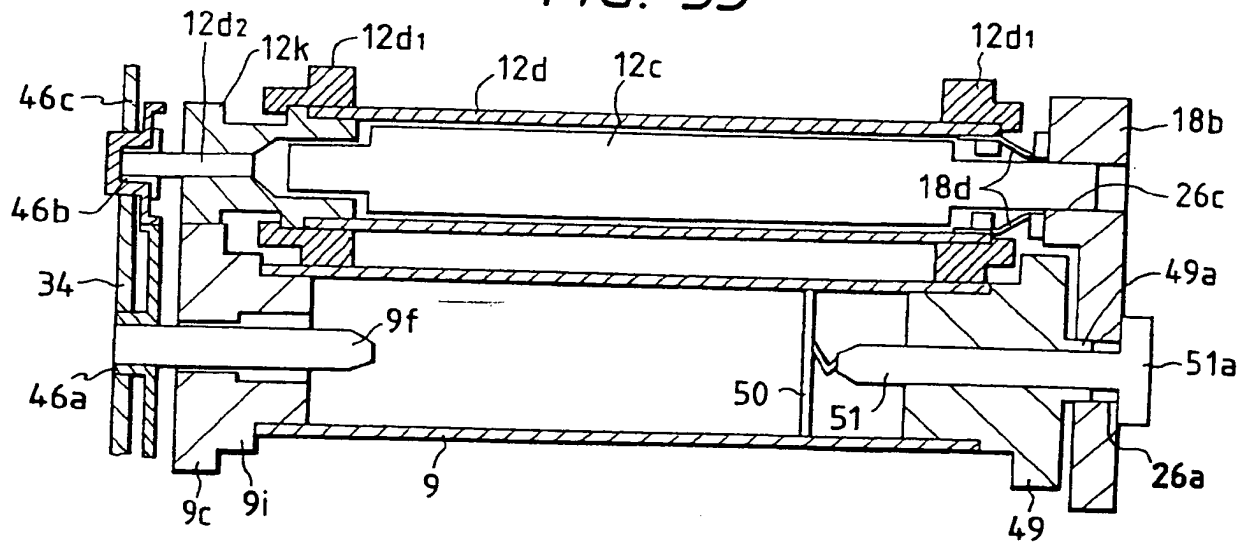


FIG. 56

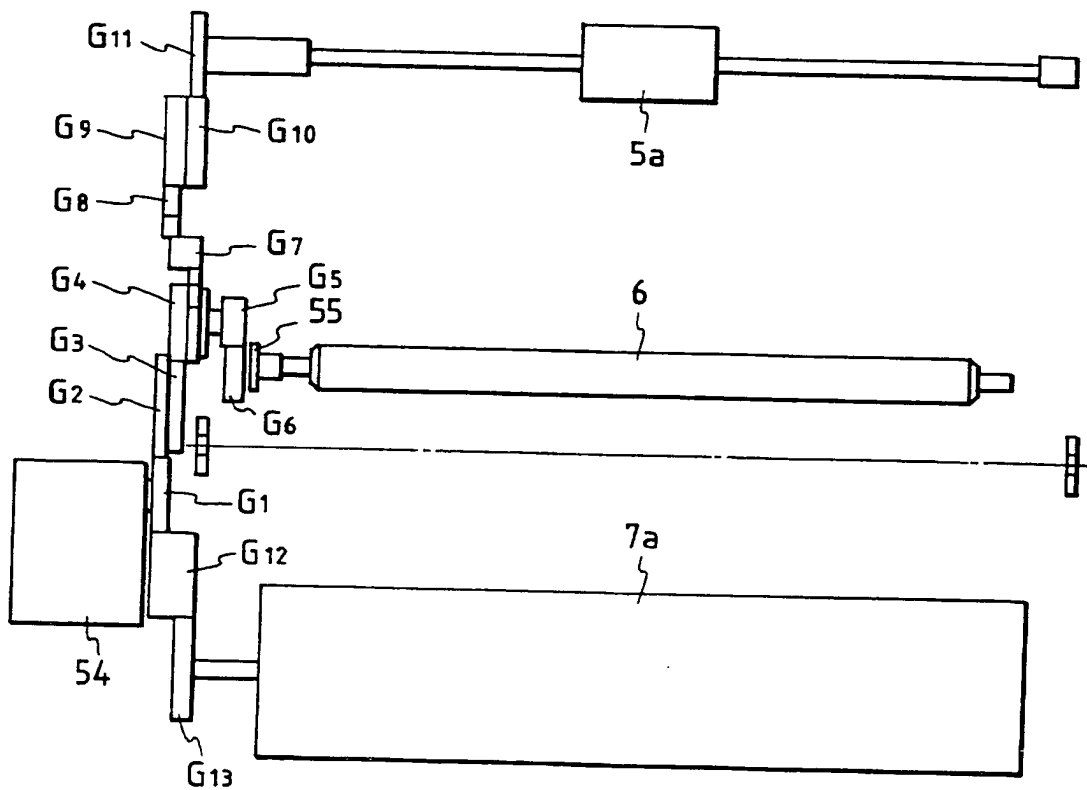




FIG. 57

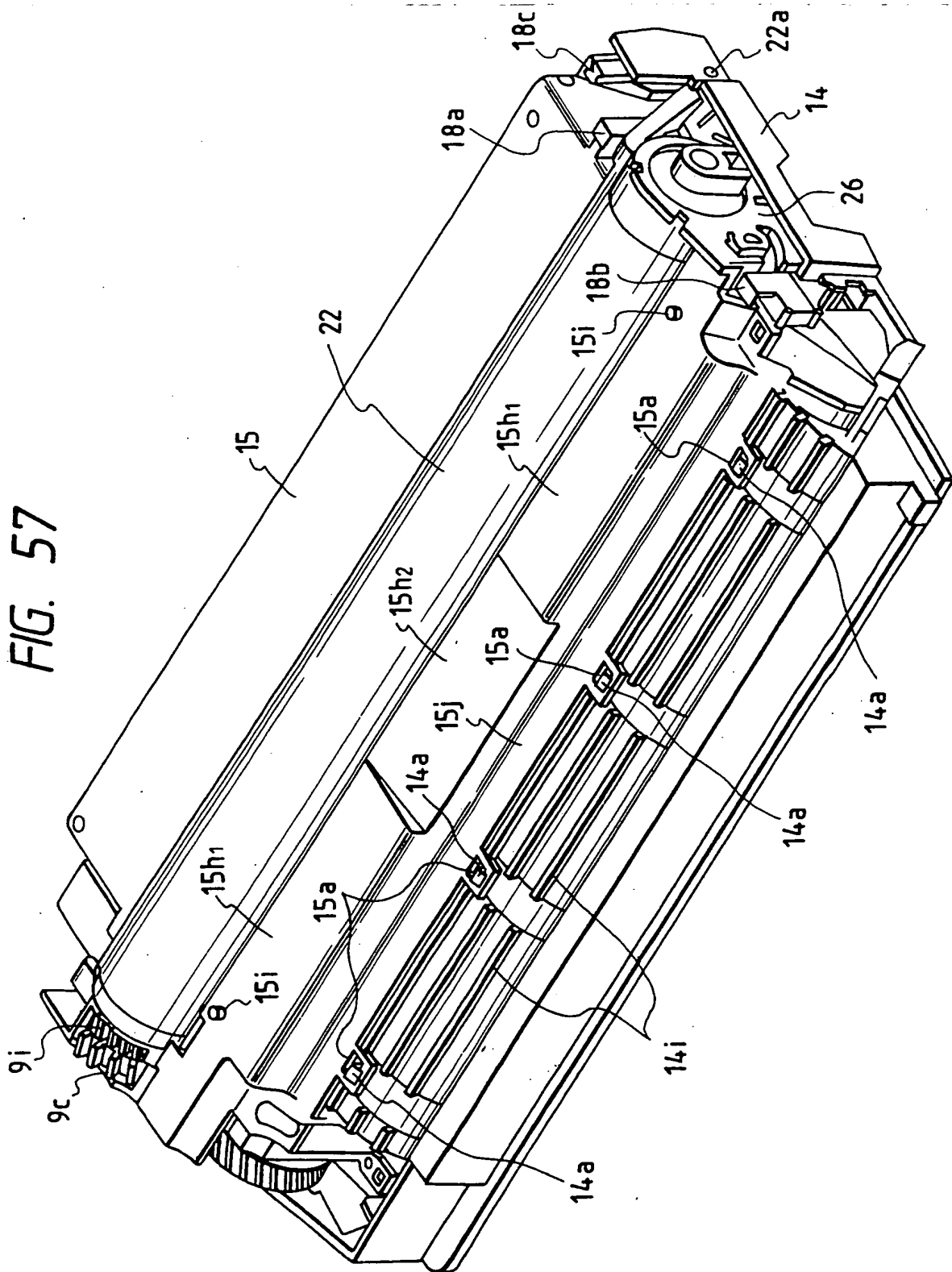


FIG. 58

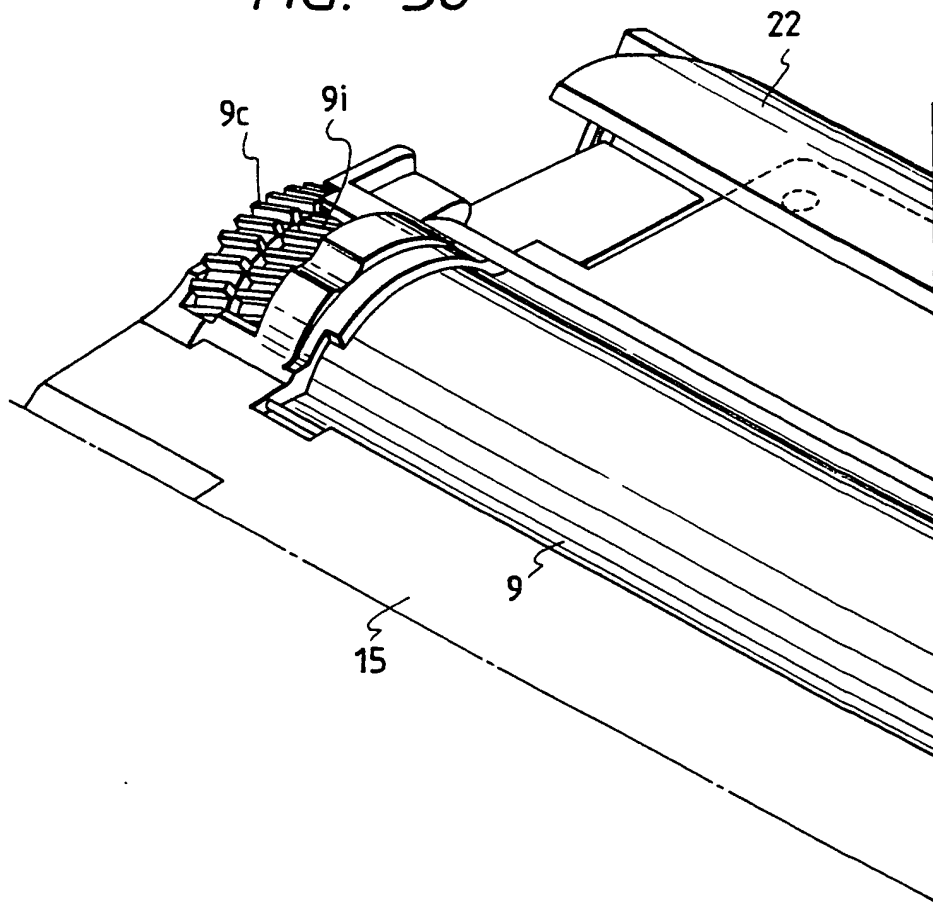


FIG. 59

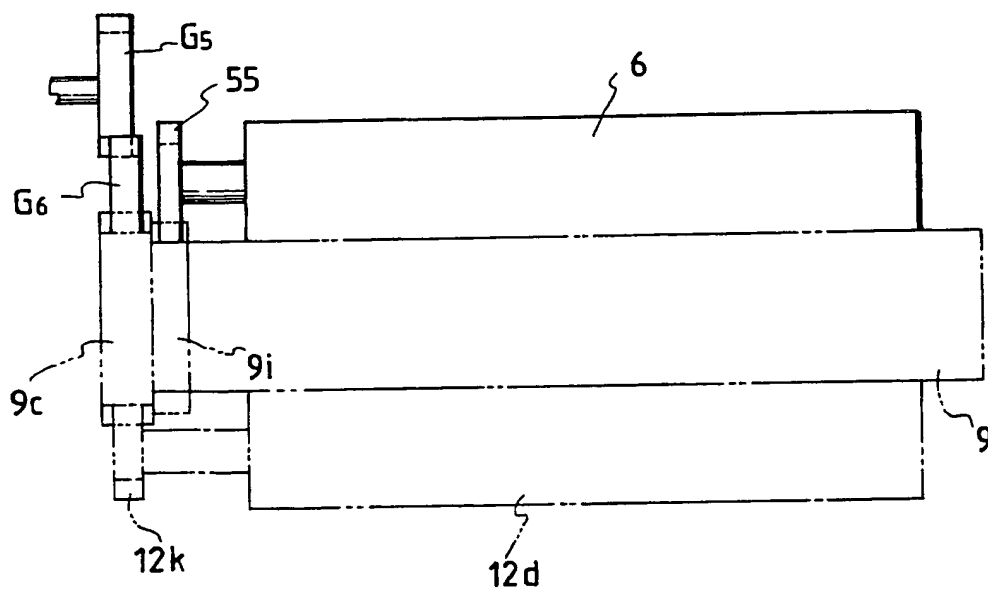


FIG. 60A

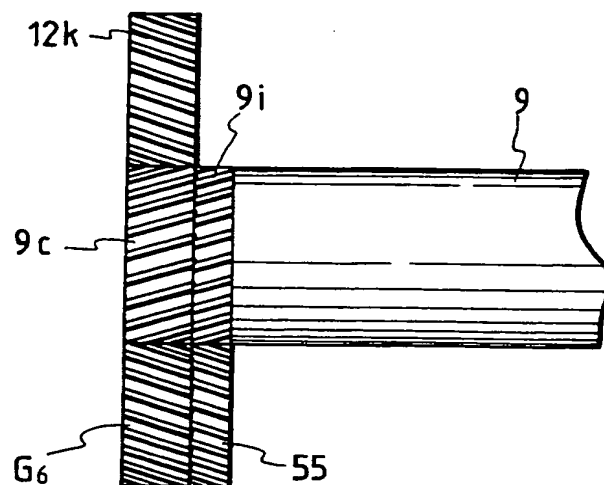


FIG. 60B

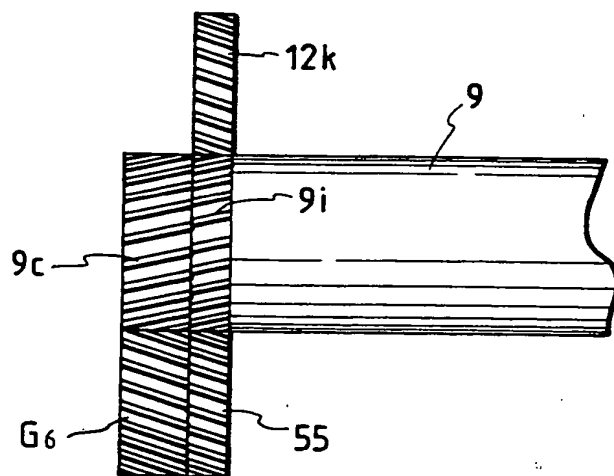


FIG. 61

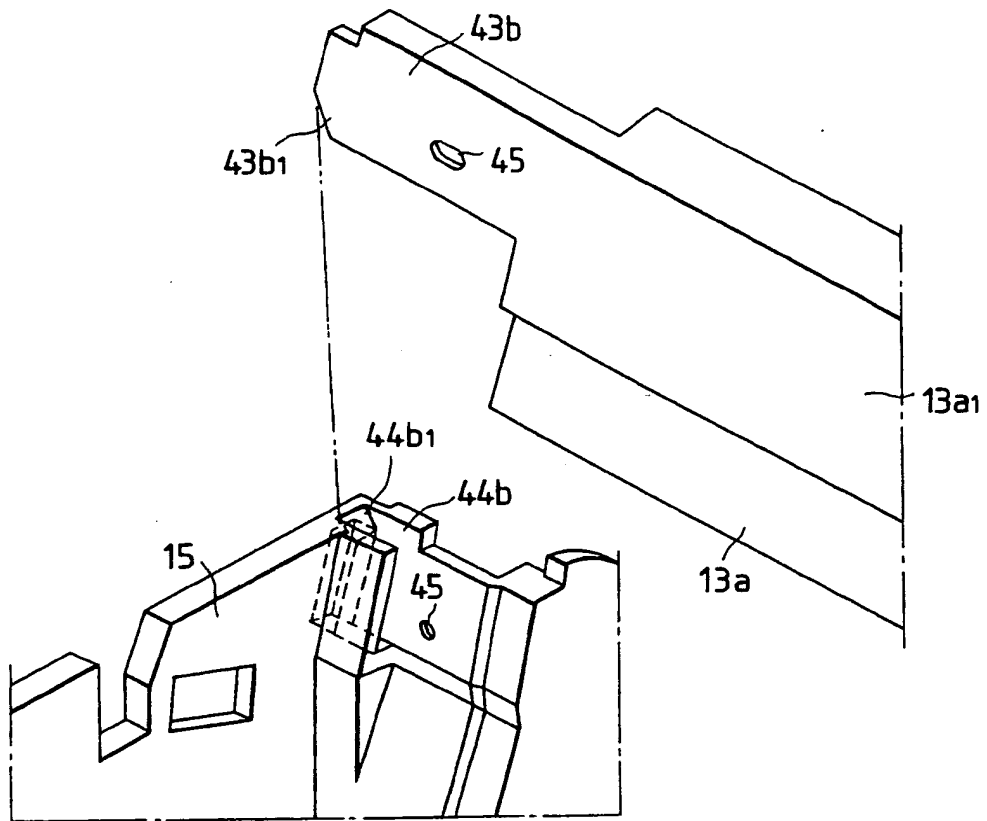


FIG. 62

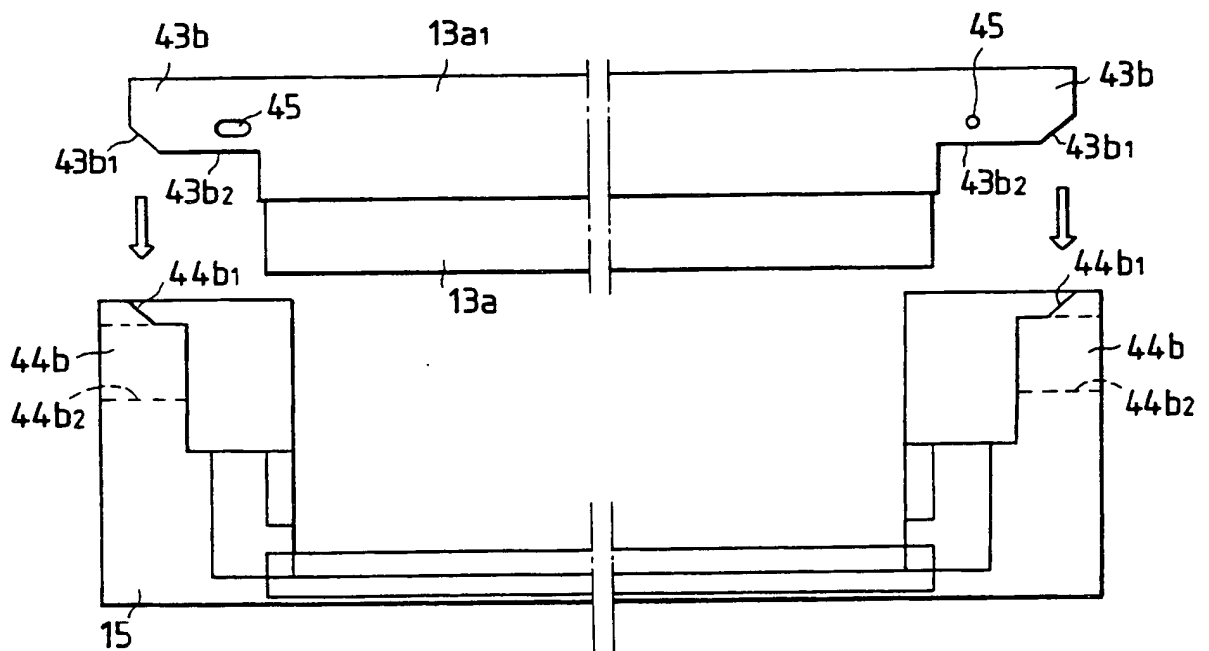


FIG. 63

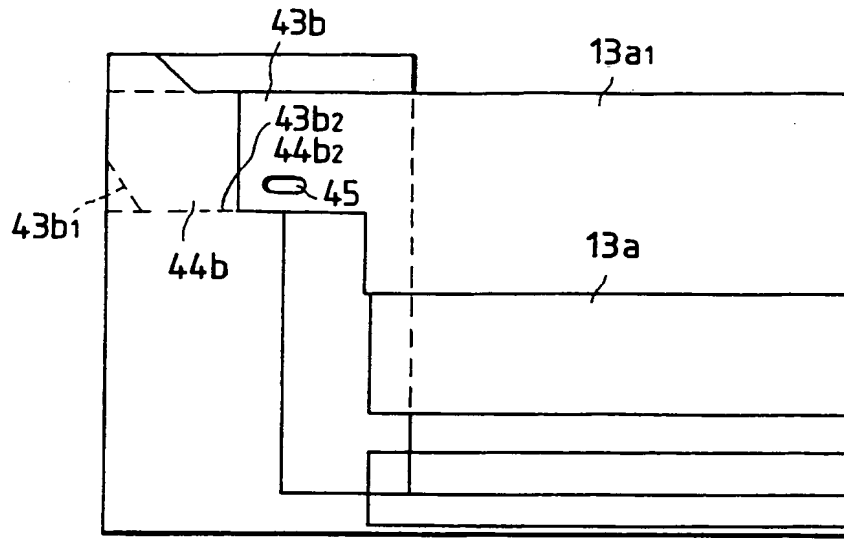


FIG. 64

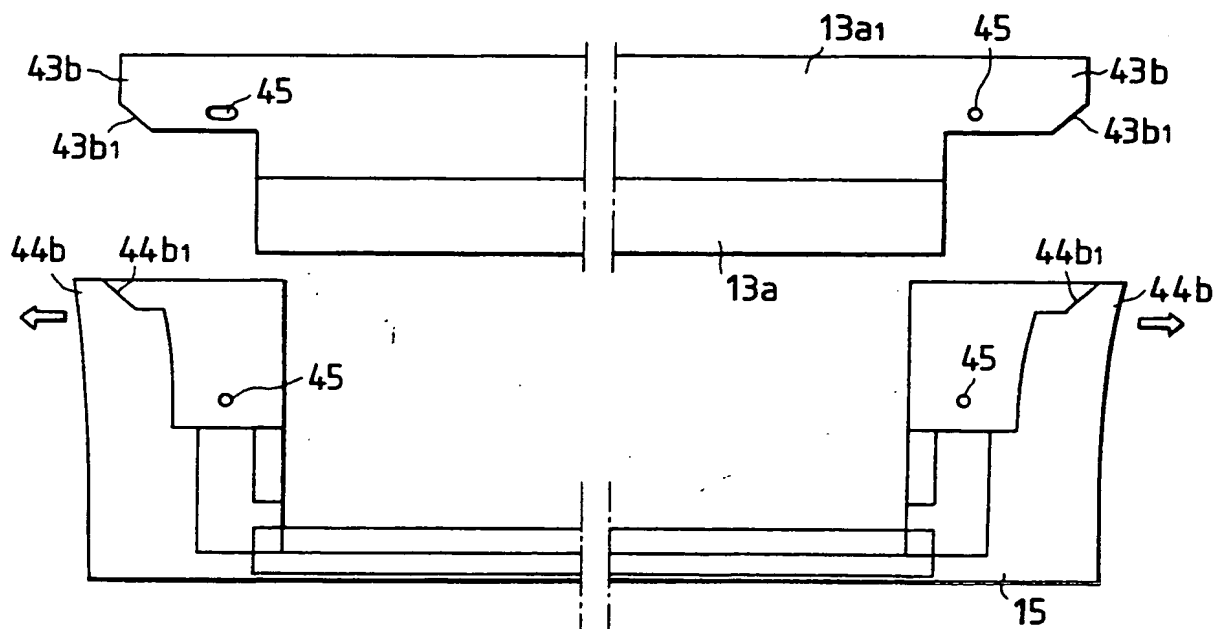
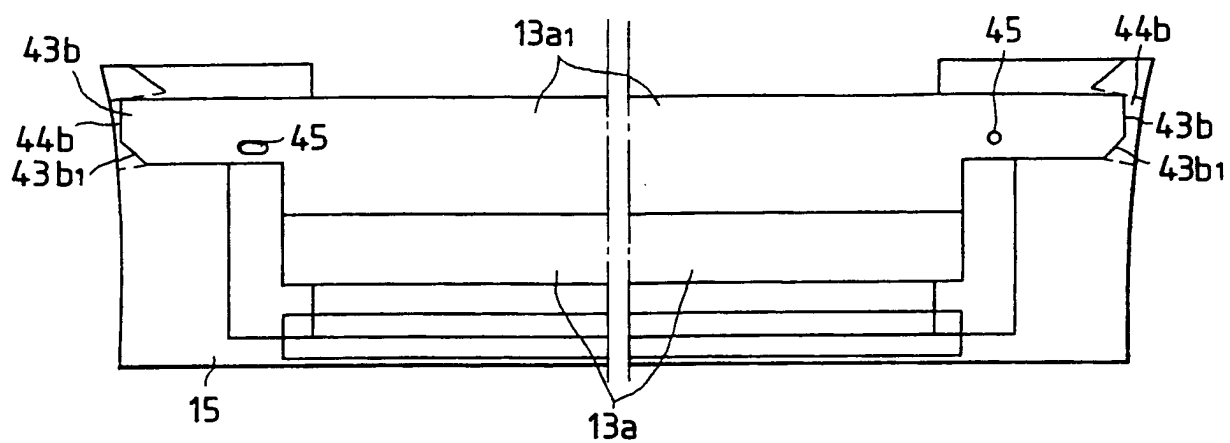


FIG. 65



**FIG. 66**

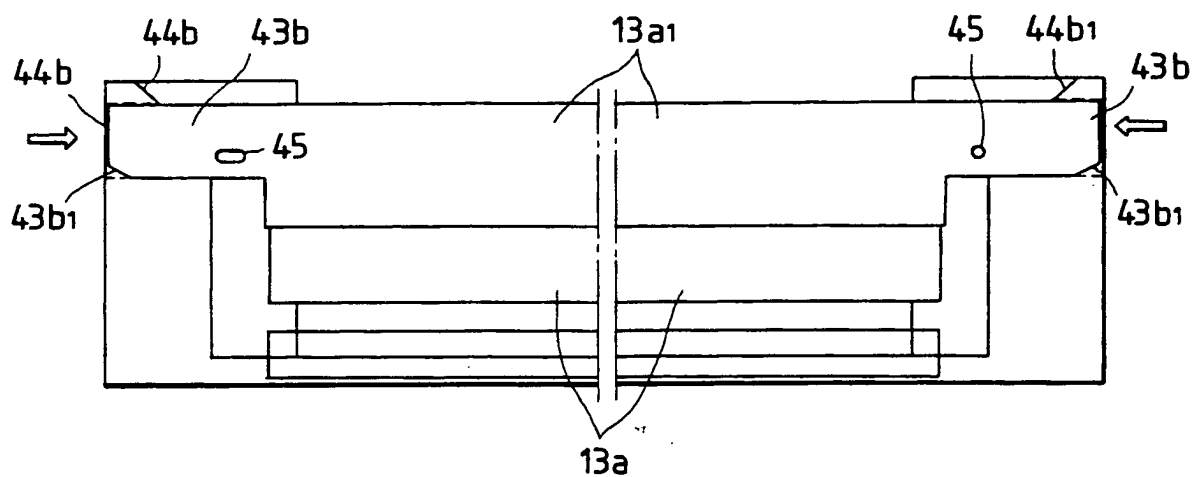


FIG. 67

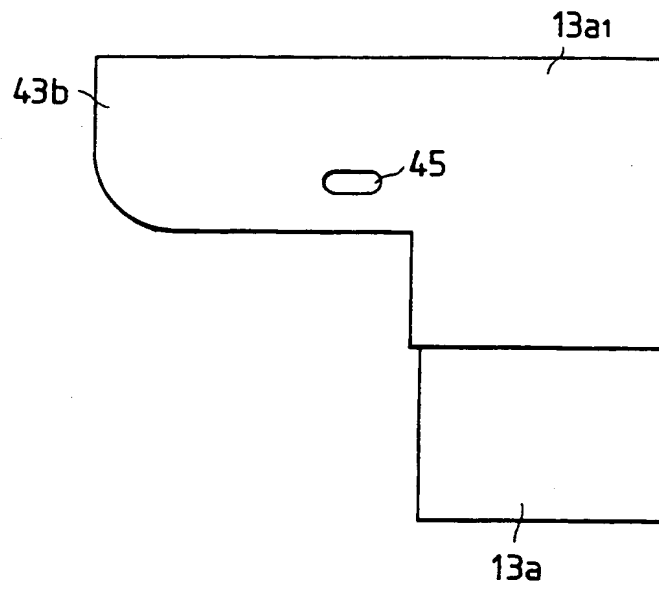


FIG. 68

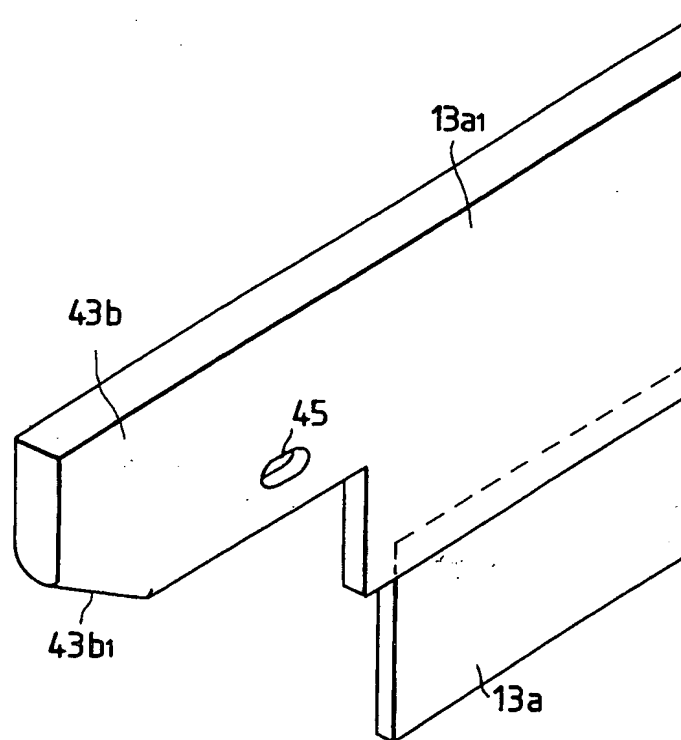


FIG. 69

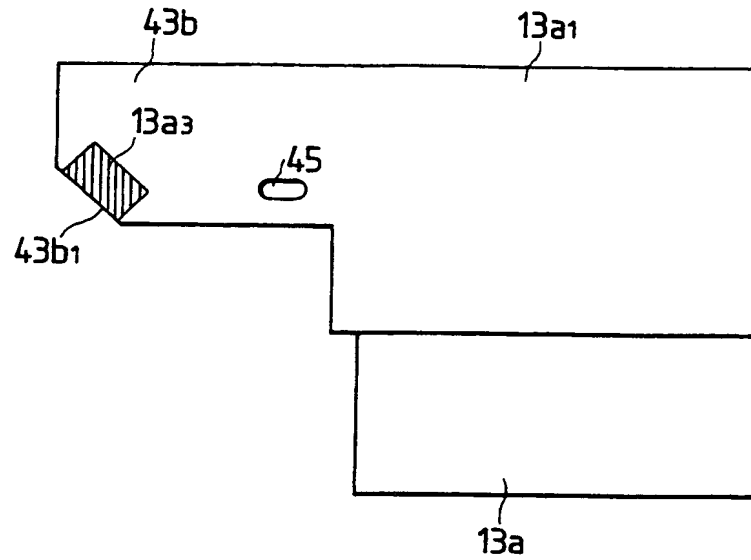


FIG. 70

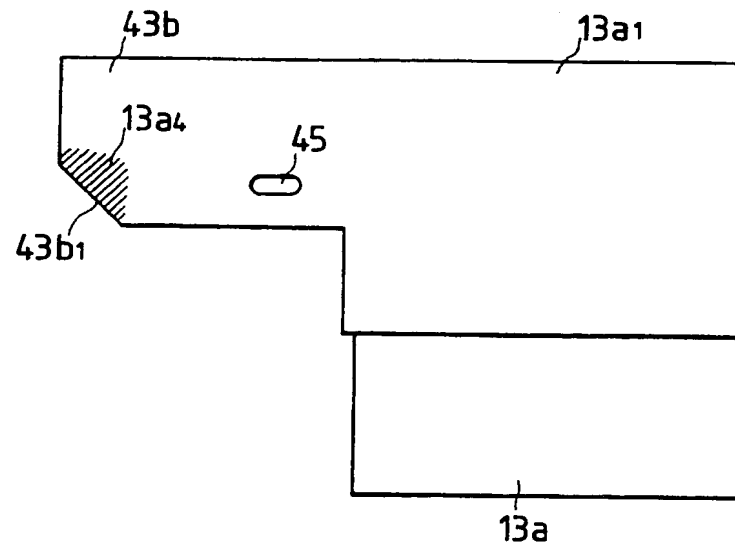




FIG. 71A

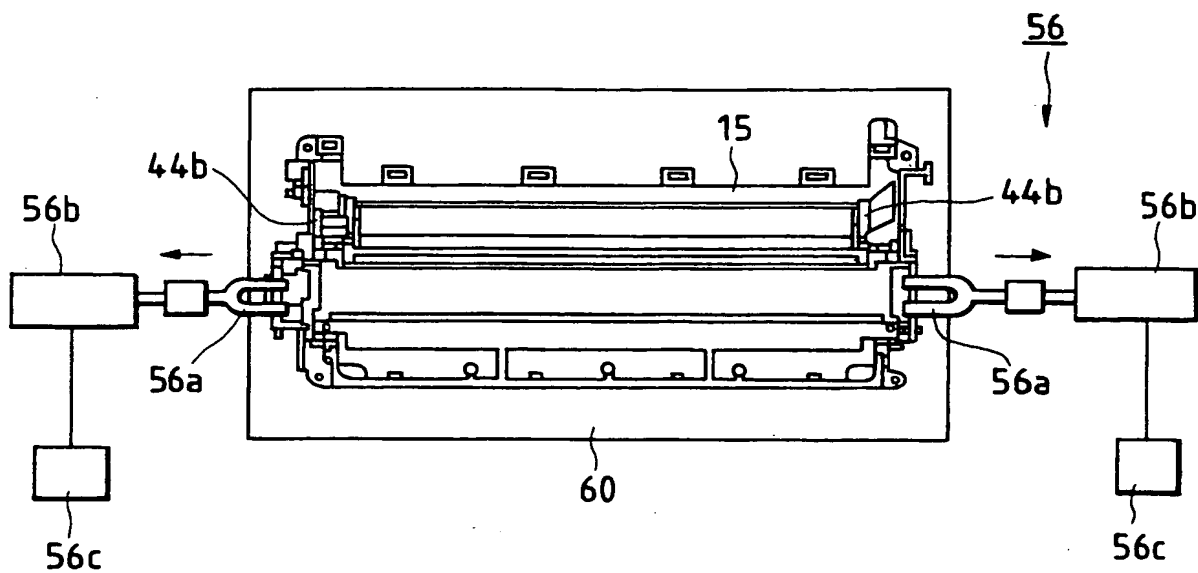


FIG. 71B

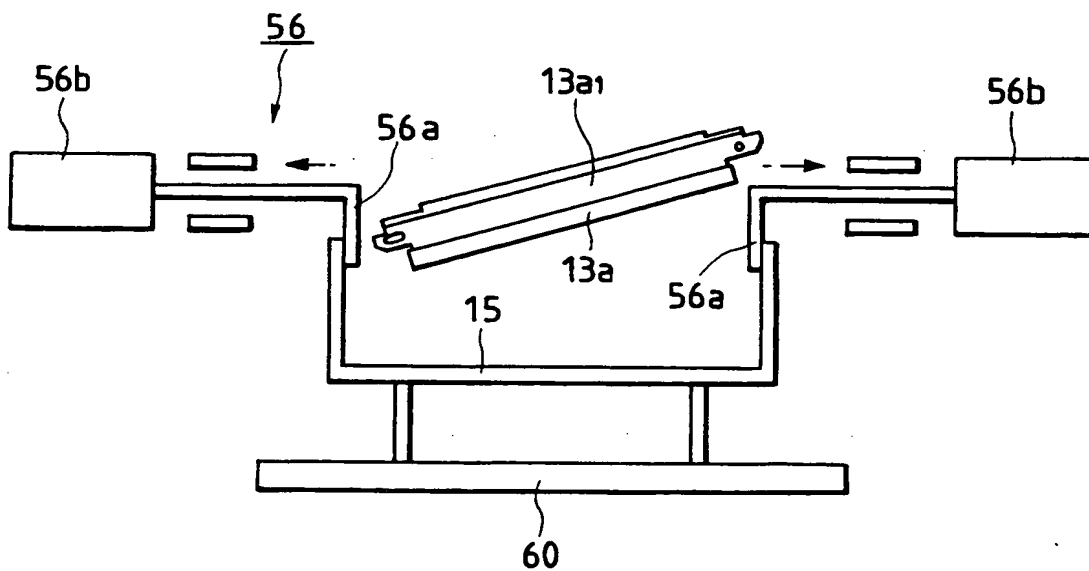
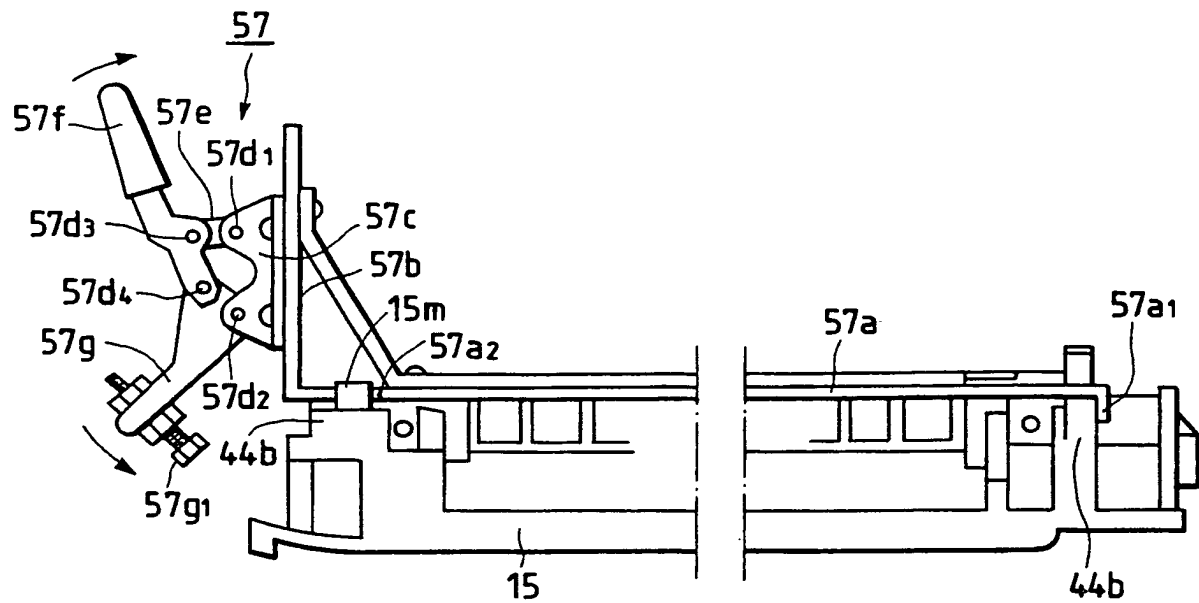


FIG. 72A



*FIG. 72B*

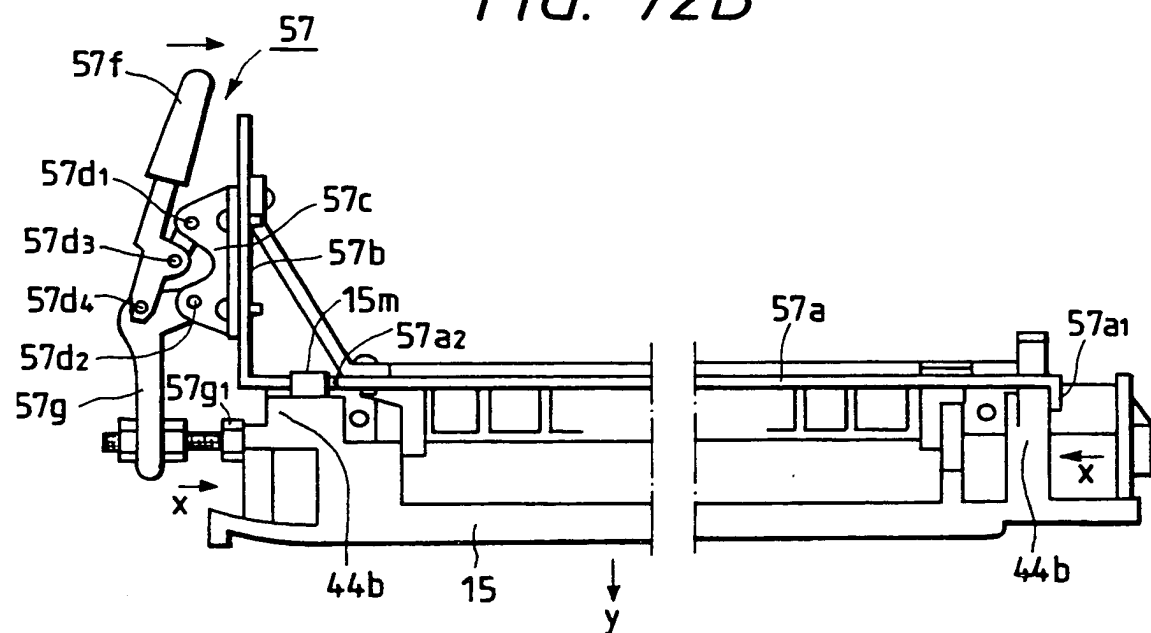
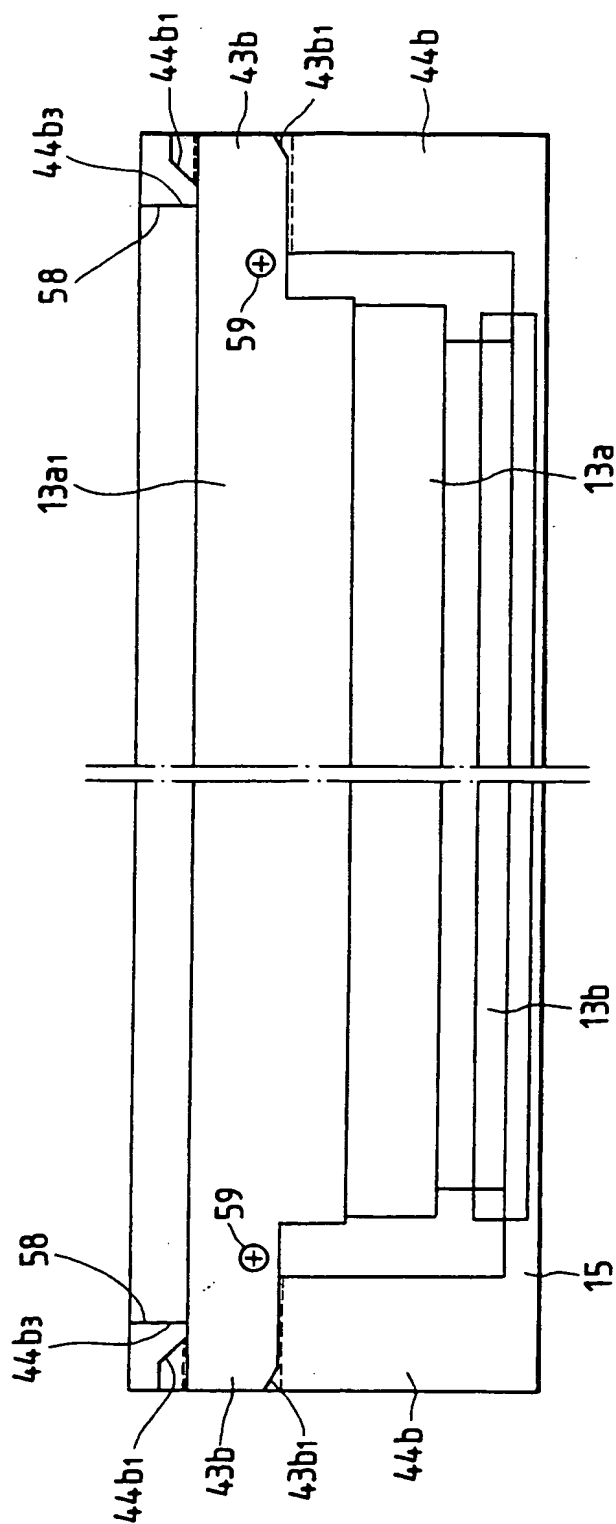


FIG. 73



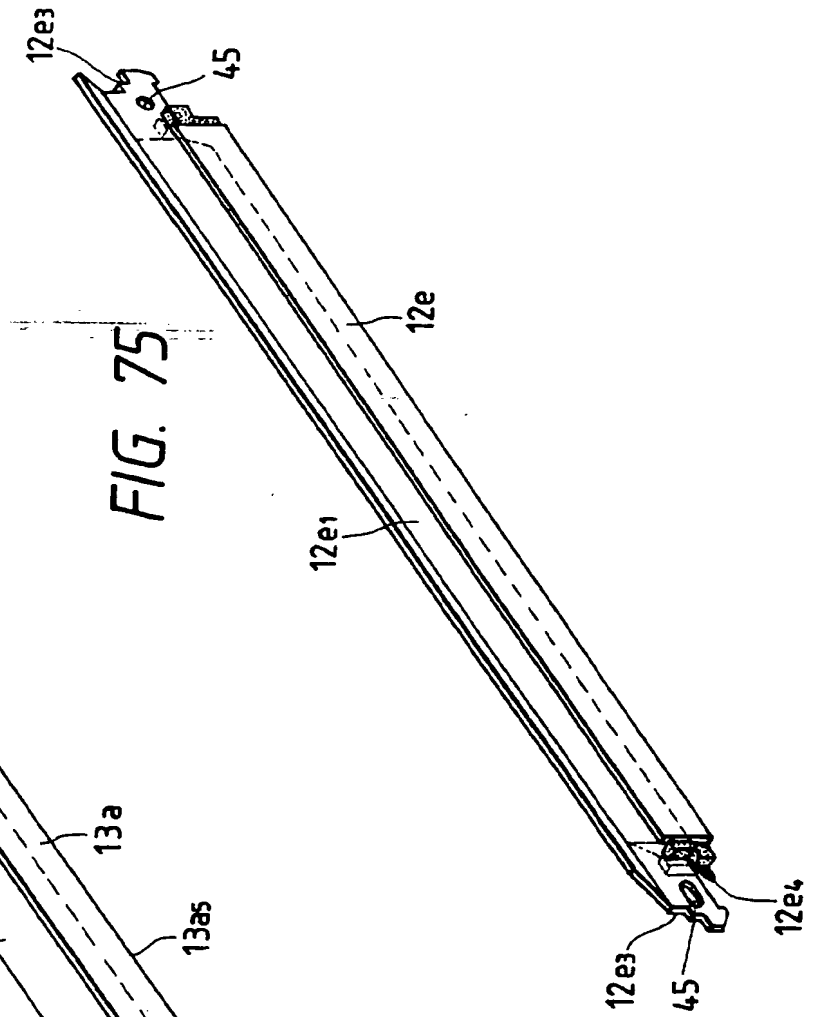
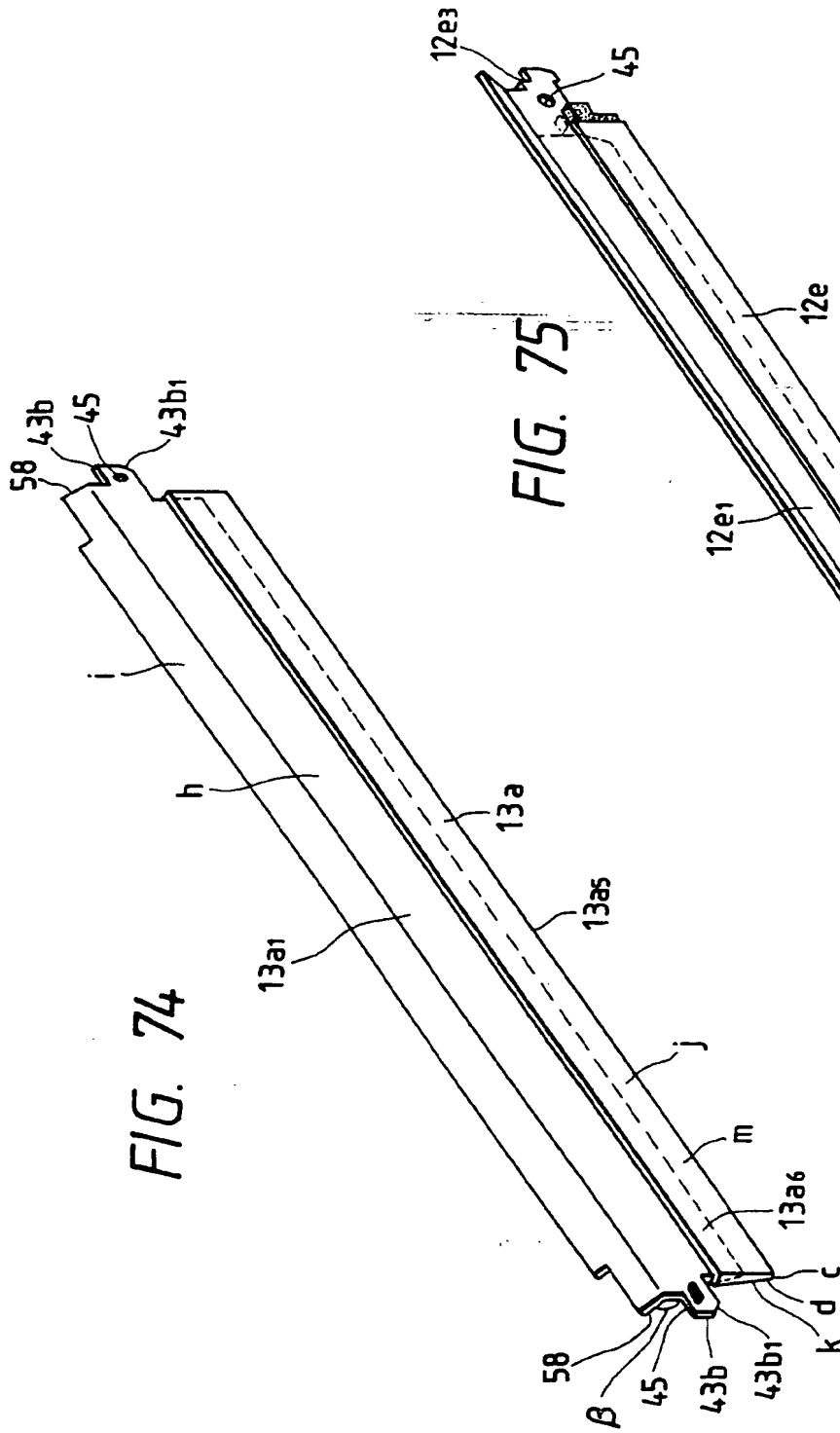


FIG. 76A

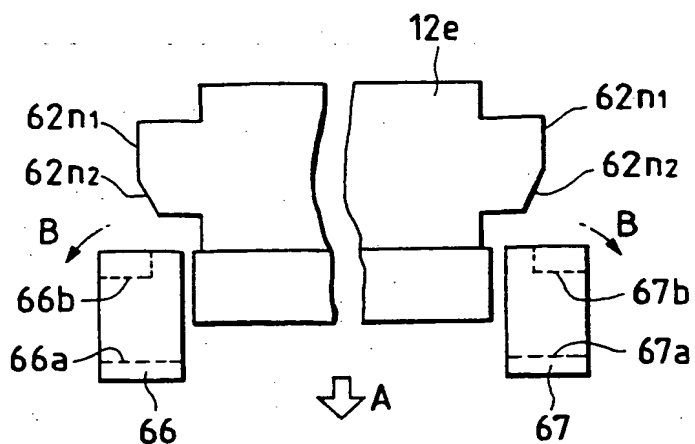


FIG. 76B

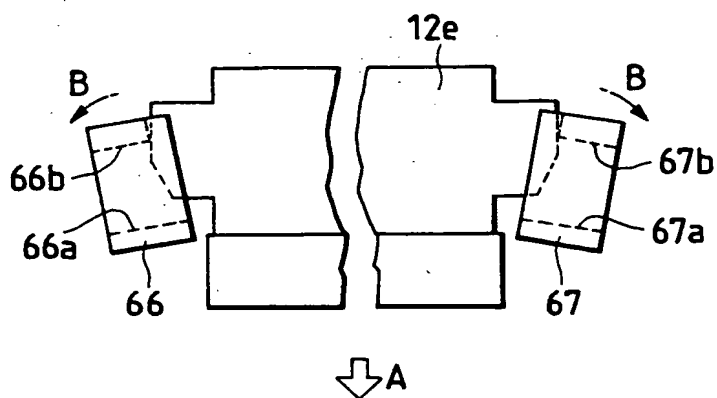


FIG. 76C

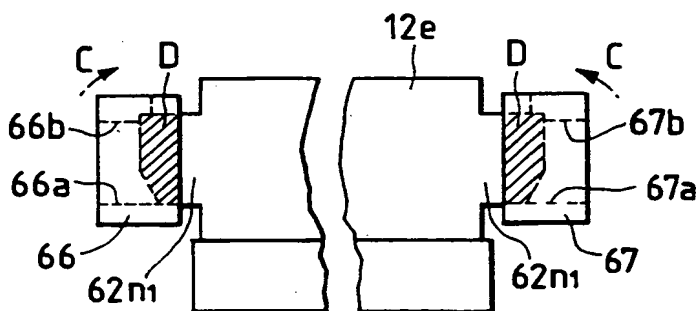


FIG. 76D

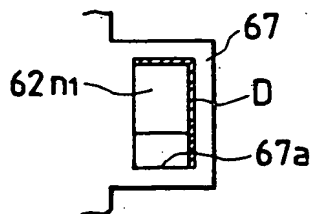


FIG. 77A

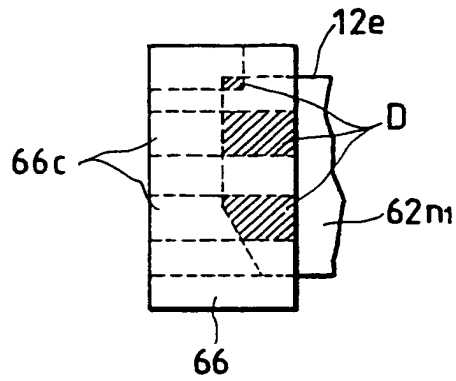


FIG. 77B

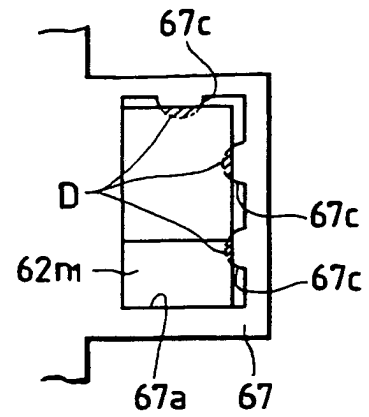


FIG. 78A

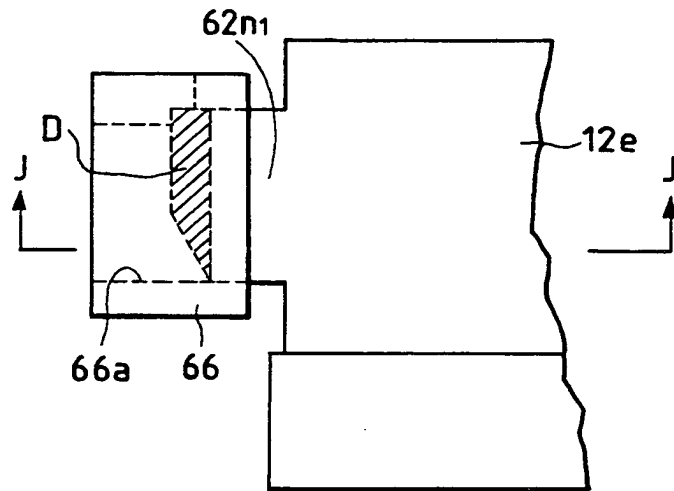


FIG. 78B

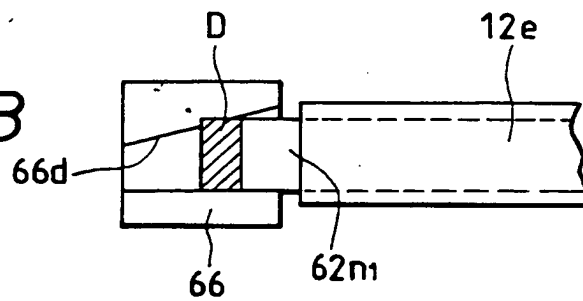


FIG. 79A

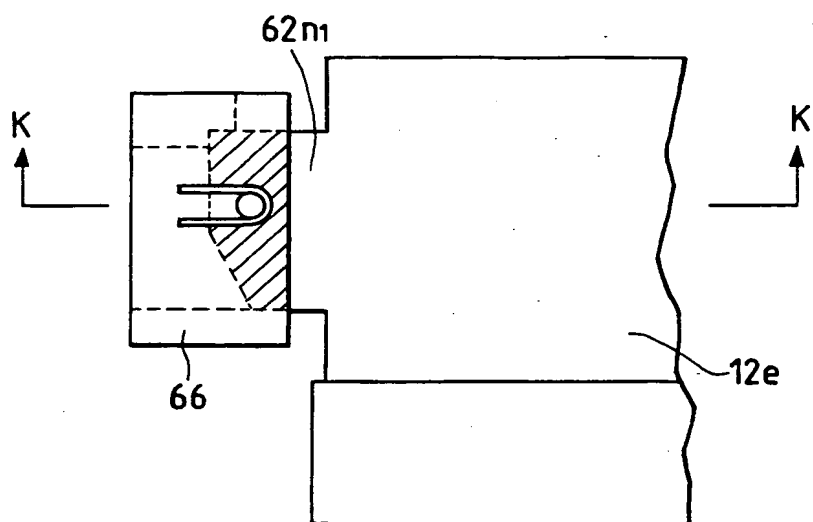


FIG. 79B

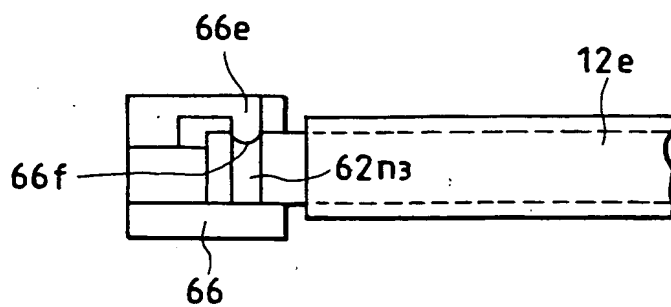


FIG. 80

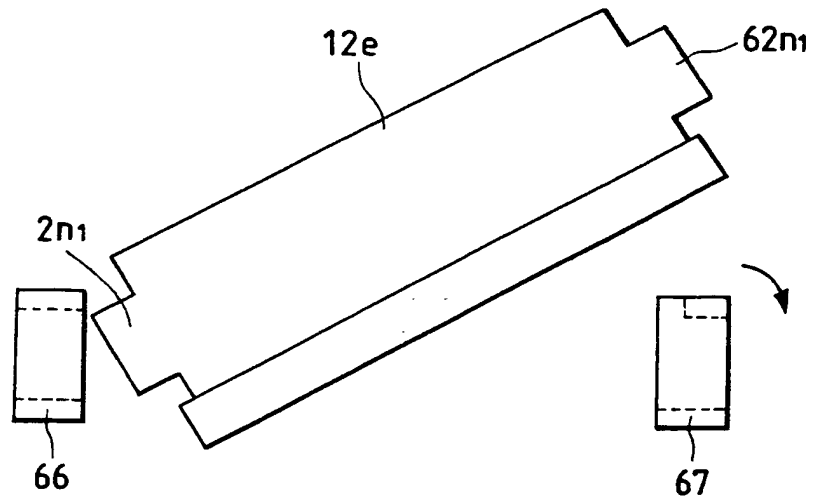
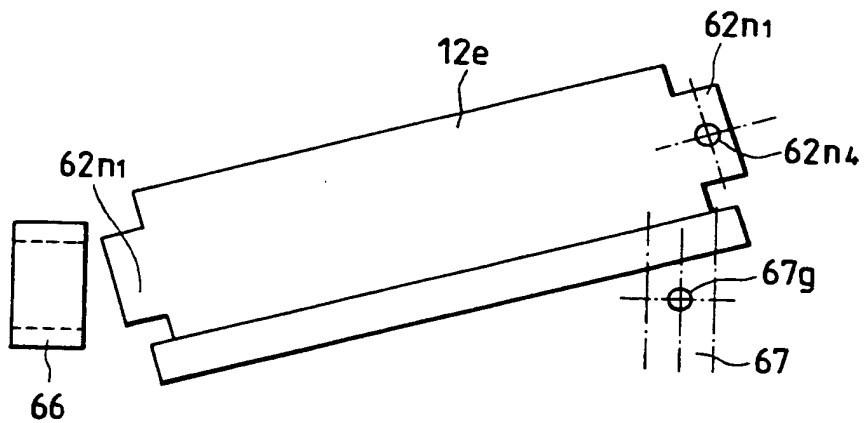


FIG. 81





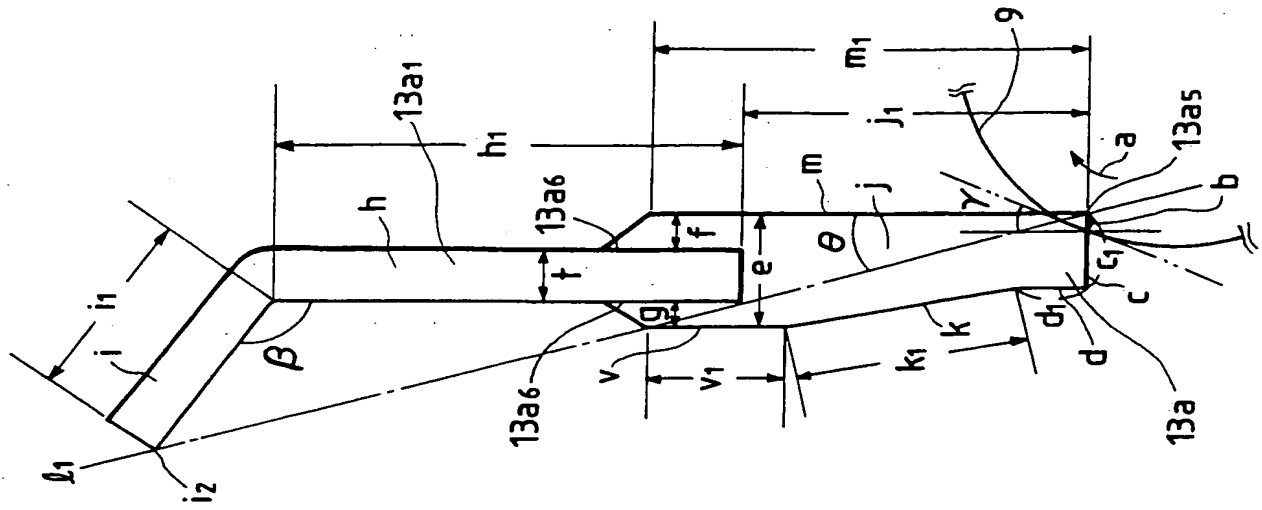


FIG. 83

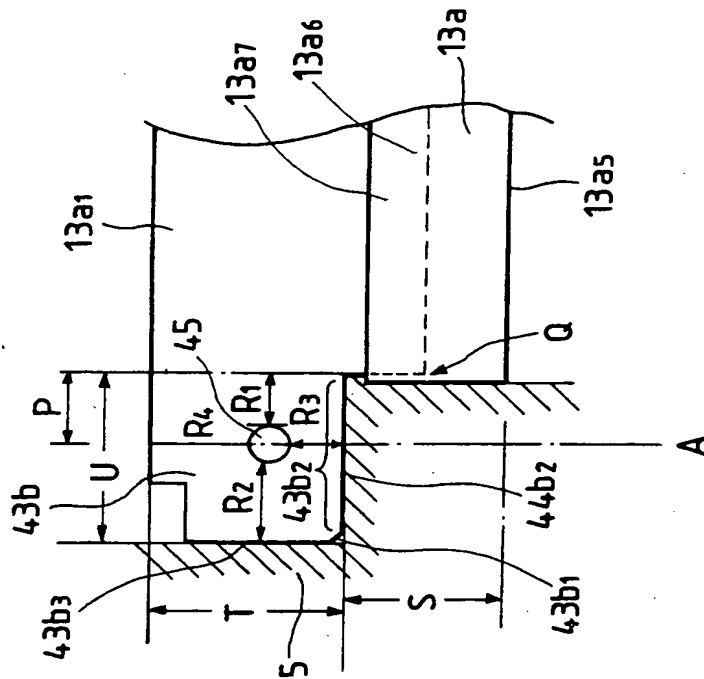


FIG. 82

FIG. 84

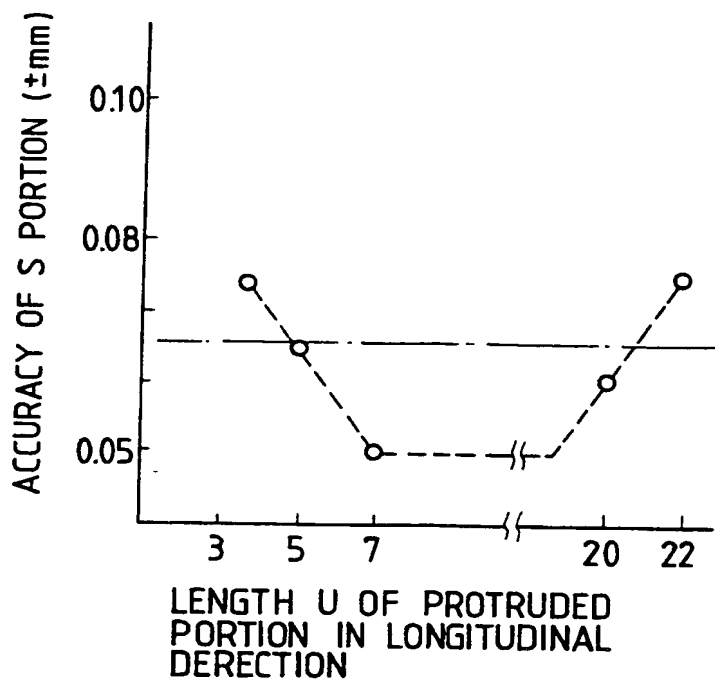


FIG. 85

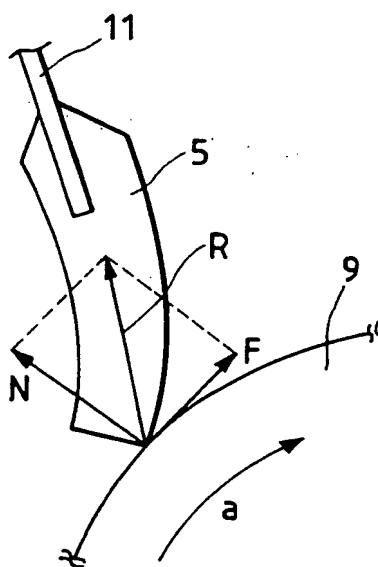


FIG. 86

	PERMANENT DEFORMATION AMOUNT (mm)	
BLADE ENTRY AMOUNT BLADE SHAPE	0.8	1.1
PRIOR ART	0.080	0.110
PRESENT INVENTION (EMBODIMENT)	0.040	0.055

FIG. 87

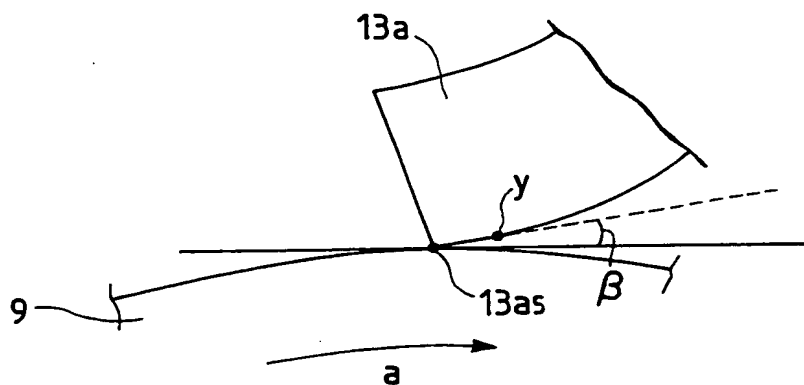
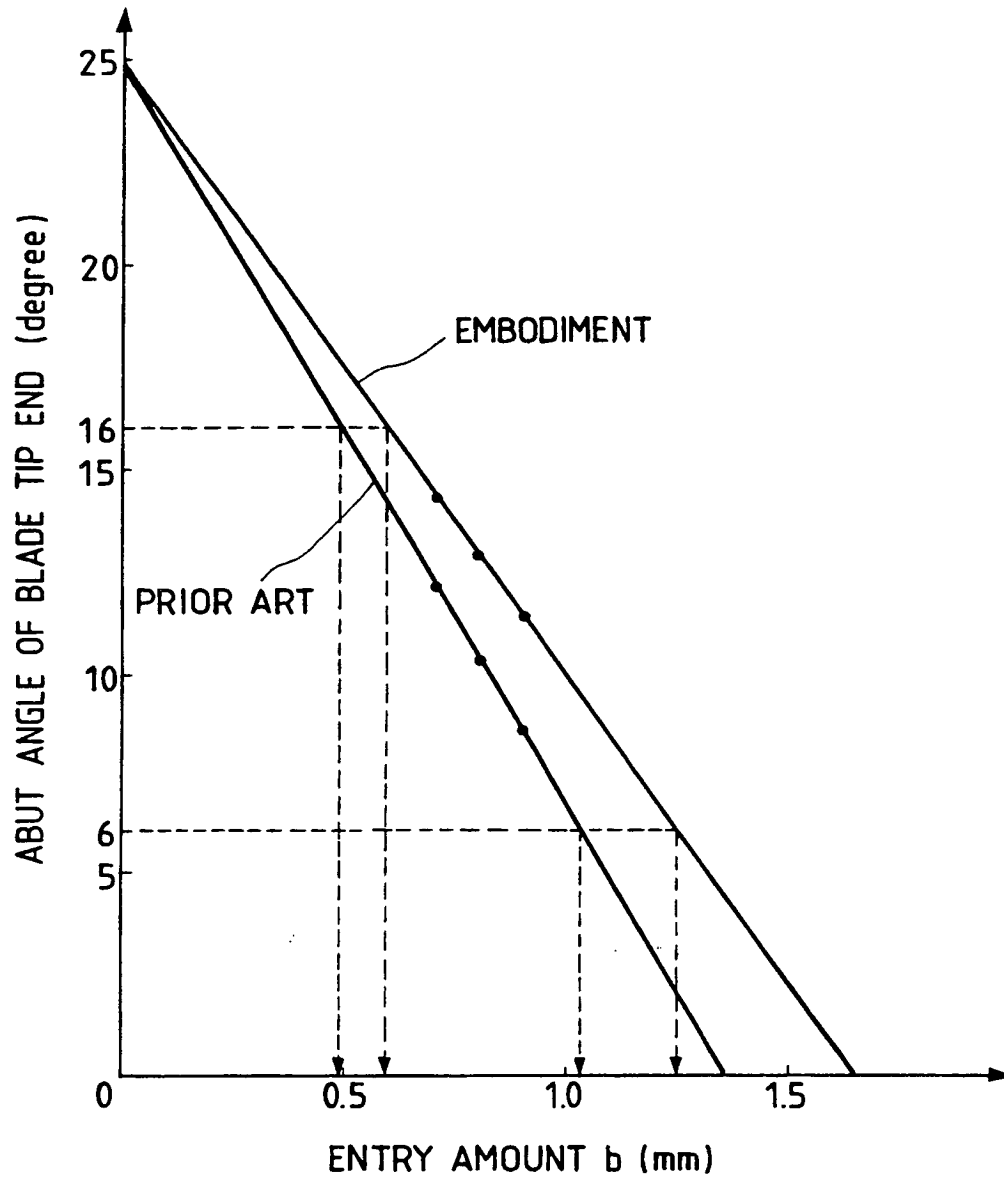


FIG. 88



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